

IDENTIFICATION : GRICON GREEN E 7018

CLASSIFICATION : AWS/SFA 5.1: E 7018, IS 814: EB5426H3 JX DIN : 5144B1026

## APPROVED BY :

EIL at CPCL site Chennai and at BPCL site, Mumbai. Also by LRS, ABS, BV, DNV, IRS, BIS(ISI), CHIEF INSPECTOR OF BOILERS BHEL (Trichy).

## DESCRIPTION :

Welders friendly heavy coated basic type, hydrogen - controlled, iron powder electrode with high deposition efficiency.

## CHARACTERISTICS :

Weld able in all positions (F.H.V.O). Welding technique including arc striking/restricting calls for practical experience for best result. The bead appearance is smooth and the slag is compact, thick and easily detachable. Deposition efficiency of weld metal is approx.115%.The welds are of radiographic quality.

## TYPICAL APPLICATIONS :

For radiographic quality welding of highly stressed crack sensitive Joints in steel structures, ship building, heavy duty boilers and pressure vessels, bridges, storage tanks, high pressure pipelines etc. Recommended for higher carbon & higher sulphur steels, which are susceptible to hydrogen induced cracking.

**REDRYING TEMPERATURE** : 250° C/ 2hrs

**DIFFUSIBLE HYDROGEN** : Max 4ml/100g of deposited weld metal.

**ASME IX Qualification** : QW- 432 F-NO 4, QW- 442 A-NO 1

**Moisture content in the flux coating** : 0.40% max

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S	P	Ni	Cr	Mo	V	Mn+Ni+Cr+Mo+V
0.10 max	0.80-1.60	0.75 max	0.03 max	0.03 max	0.30 max	0.20 max	0.30 max	0.08 max	1.75 max

MECHANICAL PROPERTIES (RANGE) : As welded

Tensile Strength MPa	0.2% Proof Stress (Yield Strength) MPa	Elongation (%) (L=4D)	Charpy V notch Impact Strength	
			Temp	Joules
510 min	440 min	24-30	27°C	120-200
			0° C	100-180
			-20°C	80-160
			-30°C	60-140

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC(70 OCV)/DC (+)	PACKING/BOX (Pcs.)	WEIGHT/1000 Pcs. (Kg)
2.50	350	60-85	150X4=600	20.5
3.15/3.20	450	100-130	100X4=400	43.0
4.00	450	130-180	65X4=260	68.4
5.00	450	180-220	45X4=180	101.5
6.30	450	220-280	25x4=120	160.0

