

GRICON GREEN(SPL) H4R VACUUM PACKED



IDENTIFICATION : GRICON GREEN (Spl) E-7018-1 H4R

CLASSIFICATION : AWS/SFA5.1: E 7018-1H4R IS814: EB5626H3 JX, BS: E5155B(11026H),
DIN : 5155B1029

DESCRIPTION :

Vacuum packed heavy coated basic type, hydrogen-controlled, iron powder electrode with high deposition efficiency. The electrode deposits weld metal which is of radiographic quality and meets impact requirements at minus 46° C. The weld deposit is tough, ductile and is highly resistant to hot or cold cracking even when subjected to high stresses, dynamic loading etc.

TYPICAL APPLICATION :

For the welding of structural steel where resistance to brittle fracture is required under adverse operating conditions such as those found in off-shore production platforms. Used for production of pressure vessels, bridges, pipelines Recommended for higher carbon & higher Sulphur steels, which are susceptible to hydrogen induced cracking. For welding SAILMA 350HI steel. For shipbuilding and ship repair application.

DIFFUSIBLE HYDROGEN : Max 4.0ml/100g of weld metal

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

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S	P	Cr	Ni	Mo	V	Combined limit for Mn+Cr+Mo+Ni+V
0.03-0.09	1.1-1.160	0.20-0.50	0.025 max	0.025 max	0.08 max	0.10 max	0.08 max	0.02 max	1.75 max

MECHANICAL PROPERTIES (RANGE) : As welded

Tensile Strength MPa (N/mm ²)	Yield Stress MPa (N/mm ²)	Elongation (%) (L=4D)	Charpy V notch Impact Value	
510-690	440-570	22% min.	Temp	Joules
			-46°C	55-110

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC (+)	PACKING PER BOX	WEIGHT 1000 Pcs
2.50	350	65-85	150×4=600	21.0
3.20	450	110-140	100×4=400	44.0
4.00	450	140-180	65×4=260	66.0
5.00	450	180-240	45×4=180	101.0