

GRIDUCT 118M



CLASSIFICATION : AWS : E 11018M IS: E76BM329Fe DIN : 8529-81~ EY 6977 Mn2NiMoBH5
BS : 2493-85 2NiMOB

DESCRIPTION :

A basic coated Hydrogen controlled Low-alloy, High Tensile Electrode. The weld metal combines very high strength properties with good fracture toughness at temperature down to minus 51°C.

APPLICABLE FOR :

Specially recommended for welding ASTM A517 Gr F Q&T steel. Excellent for welding fully killed fine grained steels. The electrode works in all position gives very little spatter with an easily removable slag leaving a bead of nice appearance. The electrodes should be redried at 350 – 400° C for 2 hours to obtain better result.

WELDING PROCEDURE : Use short arc length. Weaving of electrodes, if necessary should be done at slow speed and keeping a short arc. The electrodes should be used in perfectly dry condition. Maintain interpass temperature below 120° C.

TYPICAL USES : Penstock, earth moving equipments and heavy steel Fabrications made from high tensile steel. For welding USS -T1 steel, WEL -TEN 80 steels, SA 517 grade F and their equivalents.

DIFFUSIBLE HYDROGEN CONTENT : 2.0ml/100g of deposited weld metal (Typical) IN THE WELD METAL

WELD METAL ANALYSIS (RANGE) %:

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.09 max	1.3- 1.8	0.5 max	0.020 max	0.020 max	1.8- 2.50	0.25- 0.40	0.25- 0.50	0.05 max

MECHANICAL PROPERTIES (RANGE):

Tensile Strength	Yield Stress	Elongation (%) (L=4D)	Impact Value	
760-840 N/mm ²	680-760 N/mm ²	20 min	27°C	120-180
			-51°C	27-60

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC(90V)DC(+)	PACKING PER BOX/PCS	WEIGHT 1000 Pcs
3.15	450	90-130	110X4=440	42.75
4.00	450	140-190	70X4=280	69.07
5.00	450	190-250	45 X 4=180	107.91