

GRIDUCT 4EHT



IDENTIFICATION : Griduct 4 EHT : E9018-B3

CLASSIFICATION :AWS/SFA 5.5: E 9018- B3

WELDING PROPERTIES :

A basic coated all position, iron powder type electrode depositing 2.25 Cr / 1.0 Mo in the weld. Welds are of radiographic quality. It has excellent creep and heat resistance properties upto 550-600°C.

TYPICAL APPLICATION :

- ASTM A 199, A 200,
- A 213 Grade T22, T36 & T4
- A 182 F 22
- A 387 Grade D
- A 217 WC9
- A 335 Grade P 22

Chemical and Petrochemical industries where resistance to hydrogen attack, corrosion from sulphur bearing crude oil and stress corrosion cracking in sour atmosphere is required.

DIFFUSIBLE HYDROGEN CONTENT : Max 4.0 cc/100 g.

CURRENT CONDITIONS: AC 70 (OCV) OR DC+

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	Cr	Mo	Cu	Sb	S	P	P+Sn	As	Ni	Sn
0.05-0.12	0.5-0.9	0.25-0.60	2.0-2.50	0.90-1.20	0.20 max	0.003 max	0.015 max	0.010 max	0.016% max	0.007 max	0.30 max	0.006 max

ALL WELD MECHANICAL PROPERTIES PWHT SR at 660±10°C/water/air quenching at 940±10°C and tempering at 690±10°C :

Ultimate Tensile Strength MPa	0.2% Proof stress MPa	Elongation (%) (L=4D)	Charpy V-Notch Impact Value	
470 min	350 min	25 min	Temp	Joules
			+20°C	27 Min

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC (70V)DC(+)	PACKING/BOX (PCS)	WEIGHT/1000 Pcs (kg)
2.50	350	60-80	160X4=640	20.5
3.20	450	90-130	110X4=440	44.0
4.00	450	140-190	70X4=280	66.0
5.00	450	190-250	45X4=180	96.0