

GRIDUCT 80B6



CLASSIFICATION : AWS/SFA 5.5 E8018-B6 BS 2493-85 E5CrMoB, DIN 8575-84 EcrMo5B20+

CHARACTERISTICS :

A basic coated low hydrogen electrode depositing a low carbon 5.0% Cr / 0.50 % Mo weld metal. It is intended for welding creep resisting steels of matching composition used widely in chemical and petrochemical plants because of excellent resistance to hydrogen attack and corrosion by high sulphur crude oils at service temperatures upto 650°C.

TYPICAL USES :

- Boilers, superheaters, heat exchangers, piping and pressure vessels in oil refineries.
- ASTM A387 Gr 5
ASTM A336 Gr. F5

ASTM A155 Gr 5 Cr and

ASTM A335 Gr P5 and P5b

ASTM A213 Gr T5 and T5b

MICROSTRUCTURE :In PWHT condition : tempered bainite

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

WELD METAL ANALYSIS (RANGE) :

C	Mn	Si	S	P	Cr	Mo	Ni
0.05 -0.10	0.5 - 1.0	0.20-0.60	0.030 max	0.030 max	4.0 - 6.0	0.45-0.65	0.40 max

ALL WELD MECHANICAL PROPERTIES (RANGE) PWHT - 740°C/2Hrs :

Tensile Strength N/mm ²	Yield Stress N/mm ²	Elongation (%) (L=4D)	Charpy V-notch impact value in joules	
555-640	470-550	19.0-26.0	Temp	Joules
			27+2°C	50-120

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC (700CV)/DC(+)	PACKING PER BOX	WEIGHT IN KG. FOR 1000 Pcs (Approx.)
2.50	350	60-90	160X4=640	20.0
3.15	450	90-130	110X4=440	42.0
4.00	450	140-190	70X4=280	64.0
5.00	450	190-250	45X4=180	100.0