

GRIDUR 250



IDENTIFICATION : GRIDUR 250

CLASSIFICATION :AWS/SFA 5.5 E 8018W2 IS: E55BG129Fe EB 5326 H2JX

DESCRIPTION :

An extruded heavy coated, Chromium Nickel Copper alloyed, low hydrogen Iron Powder electrode for welding fine grained and Low Alloy Steels.

WELDING PROPERTIES:

Weldable in all Positions except vertical down. Arc is stable . Striking and restriking properties are good. Medium spatter. Slag is easy to remove. The Appearance of weld is smooth and evenly rippled, flat to convex.

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S
0.10 Max	0.5-1.3	0.35-0.80	0.03 Max

TYPICAL USES :

For welding of high strength low alloy structural steel with enhanced corrosion resistance to IRS M41-74 and similar.

MECHANICAL PROPERTIES (RANGE) :

Tensile Strength	Yield Stress	Elongation (%) (L=4D)	Impact Value
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560-620 N/mm ²	470 N/mm ²	26 min	-20C 28J
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RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC(70V) DC(+)	PACKING PER BOX	WEIGHT 1000 Pcs
2.50	350	60-80	160X4=640	21.88
3.15	450	90-130	110X4=440	46.22
4.00	450	140-190	70X4=280	71.10
5.00	450	190-250	45X4=180	108.00

APPLICABLE FOR :

For welding of fine grained steels and steels containing approximately 1 % Chromium, 0.5 % Nickel, 0.5% Copper, steels of dissimilar compositions having greater resistance to atmospheric corrosion. Excellent for weathering steels like Corten - A & B Steels, SAILCOR, ETC and of radiographic quality weld.

WELDING PROCEDURE :

Use short arc length. Weaving of electrodes. if necessary, should be done at slow - speed keeping a short arc. The electrodes should be used in perfectly dry condition. Redry the electrodes at 3500 C for one hour.