

GRIDUR M



IDENTIFICATION : GRIDUR M

CHARACTERISTICS :

An extruded , heavy coated electrode with alloys in the coating. Arc Striking and restriking properties are very good. Arc is stable. The slag is tough ,compact and uniform, covers the deposit nicely and is easy to remove. Weld metal is very smooth and finely rippled.

TYPICAL APPLICATION :

Crusher Jaws, crusher cones, excavator teeth, mill hammers, scraper blades, manganese steel, rails and crossing ,etc. Applicable for Abrasion Proof hard facing of different parts made out of mild steel, structural steels, austenitic manganese, hard steel and cast steel which are loaded by impact friction and rolling.

WELDING INSTRUCTIONS :

The deposit metal of GRIDUR - M is very tough and abrasion - Proof provided the austenitic structure is maintained. Temperature exceeding 3000 C may produce brittleness. Temperature should therefore be kept as low as possible by using low welding current. Welding of short layer is recommended to avoid concentration of heat. Hammering/peening of layers is recommended.

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S	P
1.2-1.4	12.0-14.0	0.35-0.5	0.03 max	0.03 max

HARDNESS OF WELD METAL :

1. After Welding : 180 - 200 HB

2. After Cold -working : 450 - 500 HB

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS	PACKING PER BOX	WEIGHT 1000 pCS
3.15	450	90-110	120X4=480	43.00
4.00	450	110-150	65X4=260	68.00
5.00	450	160-190	55X4=220	93.74