

GRIDUR NMR



IDENTIFICATION : GRIDUR - NMR E12015G

CLASSIFICATION : AWS/ SFA:5.5 E 12015-G, prEN 1599 : E ZCr Mo 1 NiMo 1B 42 H10

CHARACTERISTICS :

Medium heavy coated, hydrogen controlled creep resistant basic type electrode depositing low alloy 1%Cr-2.5% Ni-0.8Mo high tensile weld metal. The deposited weld metal meets x-ray quality requirements.

TYPICAL APPLICATION :

For surfacing and joint welding in machine building and construction of apparatus, as well as for repair welding of components made of similar steel grades, steam turbines, rotors. Identical and similar low alloy steels and cast steels, e.g. 24 Cr MoV 5 2 , 24 CrMoV5 5, 21 CrMoV 5 11, 36 CrNiMo 4, 28 NiCrMo 5 5, 28.

WELD METAL ANALYSIS (RANGE) % :

C	Si	Mn	Cr	Ni	Mo	S	P
0.12 max	0.2-0.6	0.6-1.0	0.8-1.25	2.10-2.80	0.8-1.10	0.03 max	0.03 max

MECHANICAL PROPERTIES (RANGE) :

	Ultimate Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L=4D)	Charpy V-notch impact strength
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AW	950-1050	800-900	13-18	Temp	Joule
				27	45-80
NT	770-870	550	15-20	27	80-140

AW= as-welded, N+T =normalized +tempered 1hr at 9200C, air cooling +1hr at 7000C,air cooling

REDRYING TEMPERATURE :

300 to 3500C for 2 hrs.

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	CURRENT CONDITIONS AC/DC (+) AMPS	WEIGHT 1000 PCS Kg (approx)
2.5	350	65-85	18.0
3.15	450	100-135	39.0
4.0	450	140-180	60.0
5.0	450	180-230	93.0
6.30	450	230-300	145.0