

**Covered Electrode for Metal-to-Metal Wear Resisting and Anti Erosion**

**G R I D U R 3 6**

- Standard                      AWS        EFe5-B
- Covering                      Low Hydrogen Type
- Tip Color                      Purple

- Application  
Overlying and repair welding of the edge on the mold, crusher and so on.

- Features
  1. GRIDUR36 is high-speed steel type covered electrode. It gives high hardness to the deposited metal as welded. The hardness is increased by tempering process. Also, it shows excellent notch toughness (excellent secondary-hardening capability).

- Welding Procedures

1. Preheating at 250~350°C is necessary. After welding, slow cooling is necessary for preventing crack.

Note: Over-preheating will increase the risk of crack.

2. The electrode should be re-dried for 30~60 minutes at over 300°C before use.

- Typical Chemical Component of Deposited Metal (%)

C	Cr	Mo	V	W	Other Elements
0.8	4.5	7.2	1.2	1.8	Si, Mn, P, S

- Typical Hardness of the Deposited Metal

	HV	HRC	HS
As Welded	700~800	60~64	81~88
Tempering: 550°Cx1hr	800~900	64~67	88~95

- Appropriate Welding Current (AC or DCEP)

Diameter (mm)	2.5	3.2	4.0
Length (mm)	350	350	350
Current (A)	60~70	60~100	100~140
Min. Quantity (Kg)	4.0	4.0	4.2

Equivalent to electrode for TIG welding: MH-115T