

# GRIBINOX 134LN

## IDENTIFICATION

GRIBINOX 134LN E410NiMo-15

## CLASSIFICATION

AWS/SFA 5.4 E410NiMo-15

## DESCRIPTION

A basic coated electrode Manufactured using ER410NiMo Grade of wire depositing weld metal having 13% Cr / 4% Ni/0.5% Mo intended for welding castings grade ASTM CA 6 NM or similar material type 410, 410 S and 405.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Mo	S	P	Cu
0.06 max	1.0 max	0.90 max	11.5 - 12.5	4.0 - 5.0	0.4 - 0.6	0.03 max	0.03 max	0.50 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
760 min	15 min	+20°C	50 min
		0°C	45 min

PWHT : 590°C ± 15°C / 8 Hrs.

## TYPICAL APPLICATIONS

- For welding and repairing hydraulic turbines, runner valve bodies, pump bowls, compressor cones, impellers and high pressure pipes in power generation, off-shore, chemical-petrochemical industries.
- ASTM F 6 NM, CA 6 NM,
- DIN 1.4313 G-X5CrNi134.

**MICROSTRUCTURE** : In the PWHT condition, the microstructure consists of tempered martensite with some retained austenite

**ASME IX QUALIFICATION** : QW-432 F-NO. 4 QW-442 A-NO. 6

## WELDING POSITION :



## PACKING PARAMETERS

Size (mm)	Length (mm)	AC (70 OCV) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 90	2 x 5 = 10	94 x 5 = 470

3.15 / 3.20	350	100 - 130	2 x 5 = 10	60 x 5 = 300
4	350	140 - 180	2 x 5 = 10	38 x 5 = 190
5	350	180 - 220	2 x 5 = 10	24 x 5 = 120