GWELD
SEAL OF TRUST

GRIBINOX 307

IDENTIFICATION
GRIBINOX 307 E307-15

CLASSIFICATION
AWS/SFA 5.4: E307-15, DIN 8556 : E18.8Mn B20,
IS 5206: E18.8 MnB45

DESCRIPTION
Heavy coated basic type electrode manufactured using stainless steel core wire depositing fully austenitic weld metal. The non-magnetic weld metal is extremely unsusceptible to cracking and possesses high deformation capacity so that stresses are equalized and relieved. Under mechanical loading, the weld metal is inclined to work harden. It resists corrosion and scaling. The deposited weld metal meets x-ray / radiographic quality code requirements. The weld metal can be PWHT without risk of sigma phase formation and consequent loss of ductility.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.04 - 0.14	5.0 - 7.0	0.80 max	0.03 max	0.04 max	17.0 - 20.0	8.0 - 10.0	0.50 max	0.75 max

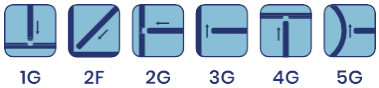
MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
590 min	30 min	20°C	60

TYPICAL APPLICATIONS
- Specially designed for joining austenitic manganese steel (12% Mn) to Mild Steel.
- For producing crack free joints in difficult steels and high alloy steels including armour plates, steel
castings.
- For surfacing manganese steel joints and crossings, and laying buffer layers on difficult steels before
hardfacing, etc.

REDRYING : 250°C / 2 hrs, max 5 cycles, 10 hrs total.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS 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	80 - 120	2 x 5 = 10	60 x 5 = 300
4	350	120 - 150	2 x 5 = 10	38 x 5 = 190
5	350	140 - 180	2 x 5 = 10	24 x 5 = 120