

GRIBINOX 308L

IDENTIFICATION

GRIBINOX 308L E 308L-15

CLASSIFICATION

AWS/SFA 5.4 E 308L-15; IS: 5206: E 19.9 LB 20

DESCRIPTION

A basic coated stainless steel electrode with a controlled composition and low ferrite content. The electrode has excellent arc stability and low spatter loss. The electrode can be manipulated easily in all welding positions. The deposited welds are of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Cr	Ni	Si	S	P
0.04 max	1.50 - 2.50	18.0 - 21.0	9.0 - 11	0.25 - 0.55	0.02 max	0.025 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
530 - 630	35 - 45	0°C	50 - 70

TYPICAL APPLICATIONS

- For welding of stainless steels types AISI 304, 304L etc.
- Food, Brewery and chemical process vessels pipelines and nuclear engineering.

REDRYING : 250°C / 2 hrs

ASME SECTION IX QUALIFACTION : QW-432 F-NUMBER, 5, QW-442 A-NUMBER, 8

WELDING POSITION :



1G 2F 2G 3G 4G 5G

PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 100	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	90 - 120	2 x 5 = 10	60 x 5 = 300
4	350	130 - 170	2 x 5 = 10	38 x 5 = 190
5	350	170 - 240	2 x 5 = 10	24 x 5 = 120