

GRIBINOX 309L

IDENTIFICATION

GRIBINOX 309L E 309L-15

CLASSIFICATION

AWS/SFA 5.4 E 309L-15 ; IS: 5206 E 23.12.LB.20

DESCRIPTION

Extra low carbon, heavy coated & basic type, all position electrode which deposits a 23% Cr, 13% Ni austenitic stainless steel weld metal. The high alloy content and ferrite level enable the weld metal to tolerate dilution from mild steel, low-alloy steels without hot cracking or brittle structure. The welds are of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Cu	Mo	S	P
0.04 max	0.5 - 2.5	0.30 - 0.90	22 - 25	Dec-14	0.75 max	0.75 max	0.03 max	0.04 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
530 - 620	30 - 40	-30°C	30 - 60

TYPICAL APPLICATIONS

- Dissimilar welds between stainless steel and C-Mn Steel.
- Overlays on C-Mn steel or low-alloy steels and for joining 304/321 clad Plate.
- Similar Metal joints, Wrought and cast steels of 23Cr-12Ni type, ASTM 309 and C8.
- Joining Ferritic-Martensitic 410 and 430 type st. steels.

REDRYING : 250°C / 2 hrs

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

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	50 - 80	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	80 - 110	2 x 5 = 10	60 x 5 = 300
4	350	110 - 150	2 x 5 = 10	38 x 5 = 190
5	350	150 - 190	2 x 5 = 10	24 x 5 = 120