

GRIBINOX 309Nb

IDENTIFICATION

GRIBINOX 309Nb E309NB-15

CLASSIFICATION

AWS/SFA 5.4: E309Nb-15

DESCRIPTION

An extruded, basic based electrode depositing 25 Cr/12 Ni/1 Nb type Stabilised stainless steel deposit. Arc is soft & stable with easy strike and restrike. Low spatter and easily detachable slag. Weld bead is finely - rippled.

The deposit is Nb - Stabilised and resistant to intergranular corrosion. It can withstand upto 1100°C. Joining stainless steel to low alloy or carbon steel.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Nb
0.10 max	1.0 - 2.50	0.9 max	0.03 max	0.03 max	22.0 - 25.0	12.0 - 14.0	0.7 - 1.0

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
560 - 660	30 min	27°C	50 - 100

TYPICAL APPLICATIONS

- Mainly used for welding 309 and 309 Nb plates service in the range upto 850°C requiring resistance to sensitisation and consequent intergranular corrosion failure in chemical plants, furnaces.
- Also used for improving wear resistance by surfacing / building up of wear surfaces of wear resistant steels subject to high temperatures upto 1100°C.
- Joining stainless steel to low alloy or carbon steel.
- Applicable for AISI 309 Cb type stainless Steels, straight chrome steels and joining stainless steel to low alloy and carbon steels.

WELDING PROCEDURE

The base metal should be free from oil, Grease or Dirt before welding. Keep a short arc - length and avoid weaving. Weld bead should be cleaned with stainless steel wire brush.

WELDING POSITION :



PACKING PARAMETERS

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

3.15 / 3.20	350	100 - 120	$2 \times 5 = 10$	$60 \times 5 = 300$
4	350	120 - 140	$2 \times 5 = 10$	$38 \times 5 = 190$
5	350	150 - 190	$2 \times 5 = 10$	$24 \times 5 = 120$