## GRIBINOX 310

## IDENTIFICATION

GRIBINOX 310, E310-15

## CLASSIFICATION

AWS A 5.4: E 310-15 IS : E 25.20 B 26 X
DIN 8556 E25.20B 23

## DESCRIPTION

An extruded, basic coated electrode for welding 25/20 Chromium Nickel Stainless Steel.

## WELD METAL ANALYSIS (RANGE) \%

| $\mathbf{C}$ | $\mathbf{M n}$ | $\mathbf{S}$ | $\mathbf{P}$ | $\mathbf{S i}$ | $\mathbf{C r}$ | $\mathbf{N i}$ | $\mathbf{M o}$ | $\mathbf{C u}$ |
| :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: |
| $0.08-0.16$ | $1.0-2.5$ | $0.03 \max$ | $0.03 \max$ | 0.75 max | $25.0-28.0$ | $20.0-22.50$ | $0.75 \max$ | 0.50 max |

## MECHANICAL PROPERTIES (RANGE)

| TS (N/mm2) | YS (N/mm2) | EL (\%) <br> (L=4D) | Impact Value |  |
| :---: | :---: | :---: | :---: | :---: |
|  |  |  | Temp | Joules |
| $560-660$ | $380-480$ | $30-40$ | $27^{\circ} \mathrm{C}$ | $70-120$ |

## WELDING PROPERTIES

Weldable in all positions. Arc striking and re-striking properties are excellent. Arc is soft \& stable. The spatter is very low and the slag is easy to remove. The weld bead is finely-rippled, smooth and regular. The deposit is highly resistant to cracking. Scale resistance upto 1000oC. The deposited weld metal is of radiographic quality.

## TYPICAL APPLICATIONS

For joining the above heat resisting steels and also for surfacing unalloyed, low / high alloy and cast steels. Furnace fabrication, apparatus, steam boilers, piping \& fittings, textile, paper, paint, rubber and glass industries, heat treatment shops, gas turbines, oil refineries, furnace fabrication, etc.

Highly stressed corrosion-resistant Stainless steel containing about 25\% Chromium \& 20\% Nickel. Also for Stainless Steel AISI grades 309 \& 310 and clad steels. Also used for joining dissimilar steels, straight Chromium Steels, welding intermediate zones between mild steel and Stainless Steels, joining difficult alloy / High Carbon Steels.

## WELDING PROCEDURE

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

## FERRITE NUMBER OF THE WELD : O

## WELDING POSITION :

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SEAL OF TRUST

PACKING PARAMETERS

| Size (mm) | Length (mm) | AMPS <br> AC 70 (0CV) / DC (+) | Packing / Box (kg) Packing / Box (Pcs) |  |
| :---: | :---: | :---: | :---: | :---: |
| 2.5 | 350 | $60-90$ | $2 \times 5=10$ | $94 \times 5=470$ |
| $3.15 / 3.20$ | 350 | $80-110$ | $2 \times 5=10$ | $60 \times 5=300$ |
| 4 | 350 | $110-140$ | $2 \times 5=10$ | $38 \times 5=190$ |
| 5 | 350 | $140-180$ | $2 \times 5=10$ | $24 \times 5=120$ |

