

# 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) %

C	Mn	S	P	Si	Cr	Ni	Mo	Cu
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/mm <sup>2</sup> )	YS (N/mm <sup>2</sup> )	EL (%) (L=4D)	Impact Value	
			Temp	Joules
560 - 660	380 - 480	30 - 40	27°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 : 0**

## WELDING POSITION :



**PACKING PARAMETERS**

Size (mm)	Length (mm)	AMPS AC 70 (OCV) / 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 - 110	2 x 5 = 10	60 x 5 = 300
4	350	110 - 140	2 x 5 = 10	38 x 5 = 190
5	350	140 - 180	2 x 5 = 10	24 x 5 = 120