

GRIBINOX 320

IDENTIFICATION

GRIBINOX 320 E320-15

CLASSIFICATION

AWS/SFA 5.4 E 320-15 ; BS: 2926: 20.34.2.CuNb.B

DESCRIPTION

Basic coated stainless steel electrode depositing fully austenitic, niobium stabilised weld metal with molybdenum and copper which has a high resistance to corrosion in sulphuric acid, other mineral acids, organic acids and their mixtures. Most parent material specifications are for castings.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
0.07	1.0 - 2.50	0.75	0.03	0.03	19.0 - 21.0	32.0 - 36.0	2.0 - 3.0	3.0 - 4.0	8 x C min Or 0.40 max
max		max	max	max					0.40 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
560 - 670	30 - 40

TYPICAL APPLICATIONS

- Tanks
- Process piping
- Heat exchangers
- Agitators & Rotors, &
- Cast Pump.
- For use in the chemical processing, metal cleaning, & pickling industries

MICROSTRUCTURE

In the as-welded condition the weld metal microstructure is fully austenitic.

REDRYING : 250°C / 2 hrs

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 80	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	70 - 110	2 x 5 = 10	60 x 5 = 300
4	350	90 - 150	2 x 5 = 10	38 x 5 = 190
5	350	120 - 190	2 x 5 = 10	24 x 5 = 120