GWELD
SEAL OF TRUST

GRIBINOX 383

IDENTIFICATION
GRIBINOX 383 E383–15

CLASSIFICATION
AWS/SFA 5.4: E 383–15, EN 1600: E 27.31.4Cu LB

DESCRIPTION
Basic type highly alloyed fully austenitic stainless steel electrode. The electrode is designed for welding ASTM NO 8028 and similar stainless steel The electrode deposits weld metal meeting X-Ray quality requirements.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.03 max	0.5 - 2.5	0.90 max	0.02 max	0.03 max	26.5 - 28.5	30.0 - 33.0	3.2 - 4.2	0.7 - 1.50

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
520 - 650	30 - 40	+20°C	45 - 80

TYPICAL APPLICATIONS
- For welding Outokumpa EN 1.4563 steel
- ASTM : N 08028
- St Steel : 2584

WELDING PRECAUTIONS
Heat in-put : Max 1.5 KJ/mm
Interpass temperature : 100°centigrate maximum

CORROSION RESISTANCE
Highly corrosion resistance in Sulphuric acid, Phosphoric acid – Excellent pitting resistance to acid solution containing Chlorides and Fluorides, Sea water.
MICROSTRUCTURE : 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	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	140 - 180	2 x 5 = 10	24 x 5 = 120