

GRIBINOX 410

IDENTIFICATION

GRIBINOX 410 E410-15

CLASSIFICATION

AWS/SFA 5.4: E410-15

DESCRIPTION

A basic coated hydrogen controlled electrode manufactured using alloyed core wire designed for welding wrought or cast martensitic (12% Cr type 410) stainless steel. The weld metal contains just sufficient carbon to enable air hardening transformation to a predominantly martensitic microstructure. The electrode exhibits good erosion and abrasion resistance. It deposits weld metal of X-ray quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Mo	S	P
0.12 max	0.40 - 0.80	0.25 - 0.60	11.5 - 14.0	0.60 max	0.75 max	0.03 max	0.04 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)
500 min	400 -450	28 min

After PWHT, 730 - 760°C / 1 hr. Furnace Cool to 315°C, then air cool.

TYPICAL APPLICATIONS

Cast valve bodies, turbine parts, burner nozzles, run-out rolls in steel mills, hydrocracker reaction vessels, furnace parts suitable for surfacing mild and low alloy steels.

DRYING OF ELECTRODES : 250 - 300°C / 2 hrs

MOISTURE IN THE FLUX COATING : 0.3% by weight, maximum

DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL : Max 4 ml/100 g

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / 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 - 130	2 x 5 = 10	60 x 5 = 300
4	350	130 - 160	2 x 5 = 10	38 x 5 = 190

