GWELD
SEAL OF TRUST

GRIBINOX 410L

IDENTIFICATION
GRIBINOX 410L E410L-15

CLASSIFICATION
AWS/SFA 5.4 E410L-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
0.04 max	0.35 - 0.80	0.25 - 0.55	11 - 13.5	0.60 max	0.50 max	0.03 max	0.04 max

MECHANICAL PROPERTIES (RANGE)

TS (N/mm2)	EL (%) (L=4D)
520 - 690	20 - 28

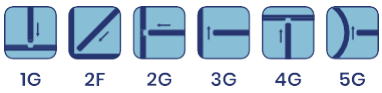
After PWHT, 730 - 760°C / 1 hr. Furnace Cool to 315°C, then air cool.

TYPICAL APPLICATIONS

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

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

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
5	350	160 - 230	2 x 5 = 10	24 x 5 = 120