GWELD
SEAL OF TRUST

GRINOX 10

AN EXTRUDED, RUTILE BASED HEAVY COATED ELECTRODE FOR WELDING 25/20 CHROMIUM NICKEL STAINLESS STEEL.

IDENTIFICATION
GRINOX 10 E310-16

CLASSIFICATION
AWS A 5.4: E 310–16, IS: E25.20 R 26 X,
DIN 8556 E25.20R 23

DESCRIPTION
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 up to 1000°C. The deposited weld metal is of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.08 - 0.16	1.0 - 2.5	0.75 max	0.03 max	0.03 max	25.0 - 28.0	20.0 - 22.50	0.75 max	0.50 max

MECHANICAL PROPERTIES (RANGE)

TS (N/mm2)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
560 - 660	30 - 40	27°C	70 - 120

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 : O

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