

GRINOX 134L

IDENTIFICATION

GRINOX 134L E 410NIMO-16

CLASSIFICATION

AWS/SFA 5.4 E 410NiMo-16

DESCRIPTION

A basic coated electrode deposits weld metal having 13 % Cr / 4 % Ni / 0.5 % Mo intended for welding castings grade ASTM CA 6 NM or similar material type 410, 410S and 405. The electrode deposits a high strength, martensitic weld metal with good resistance to hydro-corrosion (Cavitation) and sulphite induced SCC.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Mo	S	P	Cu
0.06 max	1.0 max	0.90 max	11.0 - 12.5	4.0 - 5.0	0.4 - 0.7	0.03 max	0.04 max	0.50 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
760 min	15 - 20	0°C	50 - 80

PWHT : 580oC ± 15°C / 8 Hrs.

TYPICAL APPLICATIONS

- For welding hydraulic turbines, valve bodies, pump bowls, compressor cones, impellers and high pressure pipes in power generation, off-shore, chemical-petrochemical industries.
- ASTM F 6 NM, CA 6 NM, DIN 1.4313
- G-X5CrNi134.

MICROSTRUCTURE : In the PWHT condition, the microstructure consists of tempered martensite with some retained austenite.

ASME IX QUALIFICATION : QW-432 F-NO. 4, QW-442 A-NO. 6

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 - 120	2 x 5 = 10	60 x 5 = 300
4	350	120 - 160	2 x 5 = 10	38 x 5 = 190

350

140 - 210

2 x 5 = 10

24 x 5 = 120
