GWELD
SEAL OF TRUST

GRINOX 16H

IDENTIFICATION
GRINOX 16 E316H-16

CLASSIFICATION
AWS A 5.4: E 316H-16

DESCRIPTION
A medium heavy coated rutile based electrode depositing weld metal having 18% Cr, 13% Ni, 2.5% Mo with controlled ferrite number of 3-8. Weldable in all positions. Weld bead is uniform with fine ripples and easy slag removable property. Excellent arc striking and restriking properties.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	Cu	P	Cr	Ni	Mo
0.040 - 0.080	0.5 - 2.5	0.30 - 0.90	0.03 max	0.50 max	0.03 max	17.0 - 20.0	11.0 - 14.0	2.0 - 3.0

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
550 min	30 min	27°C	60 min

TYPICAL APPLICATIONS
ASTM/ ASME, 316, CF3M, CF8M stainless steels, pulp and paper mill equipments, bleaching solutions, chemical mixers, paint and dye industries, etc.

WELDING PROCEDURE
- The base metal should be free from oil, grease or dirt
- Before welding. Keep a short arc - length. The deposited weld metal should be cleaned with stainless steel wire brush.
- Redry electrodes at 200°C / 2hrs.

REDRYING : 250°C / 2hrs., max 5 cycles, 10 hr. total
SCALING TEMPERATURE : Approx. 850°C in air.

CORROSION RESISTANCE
Good resistance to general corrosion, specially in the more severe environments e.g. dilute hot acids. Good resistance to chloride pitting corrosion.

WELDING POSITION :

PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC (70 OCV) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	65 – 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 – 140	2 x 5 = 10	38 x 5 = 190
5	350	140 – 180	2 x 5 = 10	24 x 5 = 120