

# GRINOX 308L

## IDENTIFICATION

GRINOX 308L E308L-16

## CLASSIFICATION

AWS/SFA 5.4 E308L-16, BS 2926 E19.9.L.R

DIN 8556E199LR26

## DESCRIPTION

A medium heavy coated, rutile type AC/DC electrode designed for the welding of low carbon 18% Cr / 10% Ni, type 304L, 304 austenitic stainless steel. Operability is excellent with a low spatter arc, producing a smooth weld bead surface and self-releasing slag. The electrode deposits X-ray quality weld metal.

## WELD METAL ANALYSIS (RANGE) %

| C        | Mn        | Si          | Cr      | Ni     | Cu       | Mo       | S        | P        |
|----------|-----------|-------------|---------|--------|----------|----------|----------|----------|
| 0.04 max | 0.5 - 2.5 | 0.35 - 0.90 | 18 - 21 | 09-Nov | 0.75 max | 0.75 max | 0.03 max | 0.04 max |

## MECHANICAL PROPERTIES (RANGE)

| TS (MPa) | EL (%)<br>(L=4D) | CVN Impact Value |          |
|----------|------------------|------------------|----------|
|          |                  | Temp             | Joules   |
| 520 min  | 35 - 45          | 0°C              | 60 - 100 |

## TYPICAL APPLICATIONS

- For welding ASTM/ASME 304, 304L, 304LN, Cast CF3, CF8, food brewery and chemical process vessels, pipelines and nuclear engineering. Type 301, 302 and 303.
- Also suitable for welding type 321 stabilised stainless steel, petrochemical, power and pharmaceutical industries, paper processing plant.

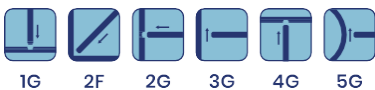
**CORROSION RESISTANCE** : Good resistance to general and intergranular corrosion. Good resistance to oxidizing acids. Not susceptible to intergranular corrosion.

**MICROSTRUCTURE** : Austenite with 3 to 9 FN (3-8% Ferrite) Typical 6FN.

**ASME IX QUALIFICATION** : QW-432 F-NUMBER 5f316, QW-442 A-NUMBER 8

**REDRYING** : 250°C / 2 hrs., max 5 cycles, 10 hr. total.

## WELDING POSITION :



## PACKING PARAMETERS

| Size (mm) | Length (mm) | AMPS<br>AC (70V) / DC<br>(+) | Packing / Box<br>(kg) | Packing / Box<br>(Pcs) |
|-----------|-------------|------------------------------|-----------------------|------------------------|
|-----------|-------------|------------------------------|-----------------------|------------------------|

|             |     |           |            |              |
|-------------|-----|-----------|------------|--------------|
| 2.5         | 350 | 60 - 85   | 2 x 5 = 10 | 94 x 5 = 470 |
| 3.15 / 3.20 | 350 | 80 - 100  | 2 x 5 = 10 | 60 x 5 = 300 |
| 4           | 350 | 110 - 140 | 2 x 5 = 10 | 38 x 5 = 190 |
| 5           | 350 | 130 - 200 | 2 x 5 = 10 | 24 x 5 = 120 |