

# GRINOX 308LT

## IDENTIFICATION

GRNOX 308LT E 308L-16

## CLASSIFICATION

AWS/SFA 5.4 E308L-16; IS: 5206: E 19.9.LR26

## DESCRIPTION

A rutile coated stainless steel electrode with a controlled composition and low ferrite content, designed for cryogenic service requiring >0.38 mm charpy lateral expansion at minus 196°C. The electrode has excellent arc stability and low spatter loss. The electrode can be manipulated easily in all welding positions. The deposited welds are of radiographic quality.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Cr	Ni	Si	S	P
0.04 max	0.50 - 2.50	18.0 - 21.0	10.0 - 11.0	0.25 - 0.55	0.02 max	0.025 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
530 - 630	35 - 45	-196°C	45/0.38 mm

## TYPICAL APPLICATIONS

- For cryogenic applications involving use of stainless steels types AISI 304, 304L etc.
- Food, Brewery and chemical process vessels pipelines and nuclear engineering.

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

**LATERAL EXPANSION AT -196°C :** 0.40 - 0.70 mm

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

## WELDING POSITION :



## PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 100	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	90 - 120	2 x 5 = 10	60 x 5 = 300
4	350	130 - 170	2 x 5 = 10	38 x 5 = 190
5	350	170 - 240	2 x 5 = 10	24 x 5 = 120