GWELD
SEAL OF TRUST

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 QUALIFACTION : 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