

GRINOX 308Mo

IDENTIFICATION

GRINOX 308 E308 Mo - 16

CLASSIFICATION

AWS/SFA 5.4 : E 308 Mo - 16

DESCRIPTION

Medium-heavy coated, rutile type electrode depositing weld metal having increased ferrite content which ensures maximum resistance to weld metal cracking when joining dissimilar steels. Deposited weld metal is of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Cr	Ni	Mn	Si	S	P	Mo	Cu
0.08 max	18 - 21	09-Dec	0.7 - 2.0	0.3 - 0.9	0.03 max	0.04 max	2.0 - 3.0	0.50 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
550 min	35 min

TYPICAL APPLICATIONS

- High strength alloyed and unalloyed construction steels, Armour steels.
- Welding of AISI 316 steel to itself or to carbon steel.
- Welding of CF8M castings.

SPECIAL INSTRUCTIONS : Dry the electrodes at 300°C for 2 hrs before use.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC 70 (OCV) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	50 - 90	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	70 - 120	2 x 5 = 10	60 x 5 = 300
4	350	95 - 140	2 x 5 = 10	38 x 5 = 190
5	350	140 - 190	2 x 5 = 10	24 x 5 = 120