

# GRINOX 4L

## IDENTIFICATION

GRINOX 4L E308L-16

## CLASSIFICATION

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

DIN 8556 E199 LR26

## 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)

UTS (MPa)	EL (%) (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

# GWELD

Size (mm)	Length (mm)	AMPS AC (70V) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 80	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