

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