

# GRINOX 9Cb

## IDENTIFICATION

GRINOX 9Cb E309Cb-16

## CLASSIFICATION

AWS/SFA 5.4: E309Cb-16 IS: E23.12Cb R 26

## DESCRIPTION

An extruded, rutile based heavy coated electrode giving 25 Cr / 12 Ni / 1 Cb type Stabilised stainless steel deposit.

Arc is soft & stable with easy strike and restrike. Low spatter and easily detachable slag. Weld bead is finely-rippled. The deposit is Cb-Stabilised and resistant to intergranular corrosion. It can withstand upto 1100°C. Joining stainless steel to low alloy or carbon steel.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Cb
0.10 max	0.5 - 2.50	0.9 max	0.03 max	0.03 max	22.0 - 25.0	12.0 - 14.0	0.7 - 1.0

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
560 - 660	30	27°C	50 - 100

## TYPICAL APPLICATIONS

- Mainly used for welding 309 and 309 Cb plates service in the flange upto 850°C requiring resistance to sensitization and consequent intergranular corrosion failure in chemical plants, furnaces.
- Also used for improving wear resistance by surfacing / building up of wear surfaces of wear resistant steels subject to high temperatures upto 1100°C.
- Joining stainless steel to low alloy or carbon steel. Applicable for AISI 309 Cb type stainless Steels, straight chrome steels and joining stainless steel to low alloy and carbon steels.

## WELDING PROCEDURE

The base metal should be free from oil, Grease or Dirt before welding. Keep a short arc - length and avoid weaving. Weld bead should be cleaned with stainless steel wire brush.

## WELDING POSITION :



## PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	70 - 90	2 x 5 = 10	94 x 5 = 470

3.15 / 3.20	350	100 - 120	$2 \times 5 = 10$	$60 \times 5 = 300$
4	350	120 - 140	$2 \times 5 = 10$	$38 \times 5 = 190$
5	350	140 - 180	$2 \times 5 = 10$	$24 \times 5 = 120$