

GRINOX 9L

IDENTIFICATION

GRINOX 9L E309L-16

CLASSIFICATION

AWS/SFA 5.4 : E 309L- 16, IS : E 23.12 LR 26,
BS 2926-84 23.12 LR, DIN 8556 E23.12 LR 23

DESCRIPTION

An extruded, rutile based heavy coated all position electrode which deposits extra low carbon 23 Cr / 13 Ni austenitic stainless steel weld metal. The high alloy content and ferrite level enable the weld metal to tolerate dilution from mild and low alloy steels without hot cracking or brittle structure.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.040 max	0.5 - 2.50	0.30 - 0.90	0.03 max	0.03 max	22.0 - 25.0	12.0 - 14.0	0.75 max	0.75 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
520 min	30 - 40	27°C	60 - 80
		0°C	55 - 80

TYPICAL APPLICATIONS

Joining of clad steels and dissimilar joints between stainless and mild or low alloy steels. Buffer layers on mild and low alloy steels prior to overlaying with E 308L electrode. Welding of similar compositions, 309 type austenitic stainless steel. Joining ferritic - martensitic stainless steel type 410 and 430.

WELDING PROCEDURE

The base metal should be free from oil, grease or dirt before welding. Keep a short arc-length. The weld bead should be cleaned with stainless steel wire brush.

REDRYING : 250°C / 2 hrs., max 5 cycles, 10 hr. total.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
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2.5	350	70 - 90	2 x 5 = 10	95 x 5 = 475
3.15 / 3.20	350	90 - 120	2 x 5 = 10	60 x 5 = 300
4	350	120 - 150	2 x 5 = 10	38 x 5 = 190
5	350	140 - 180	2 x 5 = 10	25 x 5 = 125