GWELD
SEAL OF TRUST

# GRITINOX 308 HN

**IDENTIFICATION**
GRITINOX 308 HN

**DESCRIPTION**
A Rutile flux coated electrode designed for welding stainless steel type Outokumpo 253 MA or equivalent. Operability is excellent with a low spatter arc, producing a smooth weld bead surface and self-releasing slag. The deposited weld metal is of X-ray quality.

**WELD METAL ANALYSIS (RANGE) %**

| C | Mn | Si | Cr | Ni | N | Cu | Mo | S | P |
|---|---|---|---|---|---|---|---|---|---|
| 0.05 -0.08 | 0.6 - 1.0 | 1.20 - 1.60 | 21 - 23 | 10-Nov | 0.14 - 0.20 | 0.75 max | 0.75 max | 0.03 max | 0.04 max |

**MECHANICAL PROPERTIES (RANGE)**

| TS (MPa) | YS (MPa) | EL (%) (L=4D) | CVN Impact Value | |
|---|---|---|---|---|
| | | | Temp | Joules |
| 640 - 860 | 500 - 600 | 35 - 45 | +20°C | 60 - 100 |

**TYPICAL APPLICATIONS**

For welding high temperature stainless steel, type Outokumpo 253 MA and equivalent ASTM SS 2368, 2362. The weld metal has about 8FN Ferrite which gives high resistance to cracking.

**CORROSION RESISTANCE**

Excellent resistance to high temperature corrosion.

**MICROSTRUCTURE :** Austenite with 3 to 10% Ferrite.

**REDRYING :** 300°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) |
|---|---|---|---|---|
| 2.5 | 350 | 50 - 75 | 2 x 5 = 10 | 94 x 5 = 470 |
| 3.15 / 3.20 | 350 | 80 - 120 | 2 x 5 = 10 | 60 x 5 = 300 |
| 4 | 350 | 100 - 160 | 2 x 5 = 10 | 38 x 5 = 190 |
| 5 | 350 | 130 - 210 | 2 x 5 = 10 | 24 x 5 = 120 |