

GRITINOX 316

IDENTIFICATION

GRITINOX 316 E316-17

CLASSIFICATION

AWS/SFA 5.4 E316-17

BS 2926-1984 19.12.3.R, DIN 8556 19.12.3 R26

DESCRIPTION

A rutile flux coated AC / DC electrode intended for welding of low carbon, molybdenum alloyed, acid resisting austenitic stainless steel of similar composition (316). Operability is excellent with a low spatter arc, producing an exceptionally good weld bead appearance. The deposited weld metal is of X-ray quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Cu	Mo	S	P
0.08 max	0.5 - 2.0	0.30 - 0.90	17 - 20	Nov-14	0.50 max	2.0 - 3.0	0.025 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
550 - 650	35 - 45	20°C	60 - 105

TYPICAL APPLICATIONS

For welding ASTM/ASME 316, Cast CF3M, CF8M, DIN 1.4404/1.4401, 1.4403, 1.4436. Fabrication of stainless steel structures and assemblies such as plate, pipe work, vessels, tanks, forgings and castings in the chemical, power and pharmaceutical industries, food, drink and paper processing plant.

CORROSION RESISTANCE

Good resistance to general and intergranular corrosion in the more severe environments e.g. dilute hot-acids. Good resistance to chloride pitting resistance.

MICROSTRUCTURE : Austenite with 3 to 9 FN (3-8% Ferrite) Typical 6 FN

ASME IX QUALIFICATION : QW-432 F-NUMBER 5, QW-442 A-NUMBER 8

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