

GRIBINOX 134LN



IDENTIFICATION : GRIBINOX 134LN

CLASSIFICATION :AWS/SFA 5.4 E410NiMo-15

CHARACTERISTICS :

A basic coated electrode Manufactured using ER410Ni Mo Grade of wire depositing weld metal having 13% Cr / 4% Ni/0.5% Mo intended for welding castings grade ASTM CA 6 NM or similar material type 410,410 S and 405.

TYPICAL APPLICATION :

- For welding and repairing hydraulic turbines, runner valve bodies, pump bowls, compressor cones, impellers and high pressure pipes in power generation, off-shore, chemical-petrochemical industries.
- ASTM F 6 NM, CA 6 NM,
- DIN 1.4313 G-X5CrNi134.

MICROSTRUCTURE

In the PWHT condition, the microstructure consists of tempered martensite with some retained austenite.

ASME IX QUALIFICATION : QW-432 F-NO. 4 QW-442 A-NO. 6

WELD METAL ANALYSIS (RANGE) %:

C	Mn	Si	Cr	Ni	Mo	S	P	Cu
0.05 max	0.60 - 0.90	0.60 max	11.5 - 14.0/td>	3.8 - 5.5	0.4-0.6	0.03 max	0.03 max	0.50 max

MECHANICAL PROPERTIES PWHT: 590°C/ 8 Hrs. :

Ultimate Tensile Strength MPa	0.2% Proof stress MPa	Elongation (%) (L=4D)	Charpy v-notch Impact strength in joules	
620-740	530-620	17-24	Temp	Value
			+20° C	50 min
			0° C	45 min

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC (70 OCV)/DC(+)	PACKING/BOX (PCS)	WEIGHT/1000 PCS (KG)
3.15/3.20	350/450	100-130	100X4=400	46.0
4.00	450	140-180	65X4=260	67.0
5.00	350/450	180-220	45X4=180	99.0