

# GRIBINOX 308LT



IDENTIFICATION : GRIBINOX 308LT E 308L-15

CLASSIFICATION :AWS/SFA 5.4 E 308L-15; IS: 5206 : E 19.9 LB 20

## CHARACTERISTICS :

A basic coated stainless steel electrode with a controlled composition and low ferrite content, designed for cryogenic service requiring > 0.38 mm charpy lateral expansion at minus 196°C. The electrode has excellent arc stability and low spatter loss. The electrode can be manipulated easily in all welding positions. The deposited welds are of radiographic quality.

## APPLICATION :

- For cryogenic applications involving use of stainless steels types AISI 304, 304L etc.
- Food, Brewery and chemical process vessels pipelines and nuclear engineering.

## WELD METAL ANALYSIS (RANGE) % :

C	Mn	Cr	Ni	Si	S	P
0.04 Max	0.50-2.50	18.0-21.0	9.0-11	0.25-0.55	0.02 max	0.025 max

## MECHANICAL PROPERTIES (RANGE) :

Ultimate Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L=4D)	Charpy V-notch impact strength, in joules
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530-630	390-480	35-45	Temp	Impact Joule
			-196°C	35-70 J

**ASME SECTION IX QUALIFACTION :** QW-432 F-NUMBER, 5, QW-442 A-NUMBER, 8

**LATERAL EXPANSION AT -196° C :** 0.40 – 0.70 mm

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

**RECOMMENDED CURRENT AND PACKING DATA :**

SIZE (mm)	LENGTH (mm)	AMPS DC(+)	PACKING PER BOX	WEIGHT 1000 Pcs
2.50	350	60-100	600	21
3.15	350	90-120	360	32
4.00	350	130-170	240	51
5.00	350	170-240	150	76