GRINOX 307XW

IDENTIFICATION : GRINOX E307-16

CLASSIFICATION : AWS/SFA 5.4 : E 307-16, DIN 8555 : E8-UM-200-CK

CHARACTERISTICS :

Rutile coated electrode which undergoes cold work hardening, wear & heat resistant, is tough, suitable austenitic ferrite joints, stainless.

TYPICAL APPLICATIONS :

For depositing tough stress-equalizing interlayers beneath hardfacings, for filling deeply worn areas, for repairing rails, track bends and cavitation damage on water turbines, for hardfacing sealing faces on valves (acid mine water), used for welding combinations of high-alloy, stainless/ heat– resistant Cr and CrNi (Mo, N) steels/ cast steel grades and unalloyed/lowalloy parent metals, and for joining difficult –to-weld steels(e.g. armour steel), all joints welded on unalloyed/low-alloy parent metals admissible for service temperatures up to300°C only because of the risk of fracture caused by carbide precipitation at grain boundaries in the fusion zone.

FERRITE NUMBER : FN O

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

WELD METAL ANALYSIS (RANGE) % :

C	Cr	Ni	Mn	Si	S	P	N	Cu
0.06-0.12	18.0-21.50	8-10.0	5-7	0.90 max	0.03 max	0.04 max	0.12	0.75 max

ALL-WELD MECHANICAL PROPERTIES :

Ultimate Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L=4D)	Charpy V-notch Impact Strength	
			Temp	Joules
590-690	320 min	30-45	20°C	60-100

CURRENT CONDITION/PACKING SPECIFICATION :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC(+)	PACKING PER BOX	WEIGHT 1000 Pcs
2.50	350	60-90	100X5=500	21.50
3.15	350	80-120	60X5=300	33.00
4.00	350	120-150	40X5=200	53.0
5.00	350	140-180	25X5=125	79.0