

GRINOX 9CB



IDENTIFICATION : GRINOX - 9 Cb

SPECIFICATIONS : AWS/SFA 5.4: E 309Cb - 16 IS : E 23.12 Cb R 26

DESCRIPTION :

An extruded, rutile based heavy coated electrode giving 25 Cr/12 Ni/1 Cb type Stabilised stainless steel deposit.

CHARACTERISTICS :

Arc is soft & stable with easy strike and restrike. Low spatter and easily detachable slag. Weld bead is finely- rippled. The deposit is Cb- Stabilised and resistant to intergranular corrosion. It can withstand upto 1100° C. Joining stainless steel to low alloy or carbon steel.

TYPICAL USES :

Mainly used for welding 309 and 309 Cb plates service in the fange upto 850°C requiring resistance to sensitization and consequent intergranular corrosion failure in chemical plants, furnaces. Also used for improving wear resistance by surfacing /building up of wear surfaces of wear resistant steels subject to high temperatures upto 1100°C. Joining stainless steel to low alloy or carbon steel. Applicable for AISI 309 Cb type stainless Steels, straight chrome steels and joining stainless steel to low alloy and carbon steels.

WELDING PROCEDURE :

The base metal should be free from oil, Grease or Dirt before welding. Keep a short arc-length and avoid weaving. Weld bead should be cleaned with stainless steel wire brush.

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S	P	Cr	Ni	Cb
---	----	----	---	---	----	----	----

0.10 max	1.0-2.50	0.9 max	0.03 max	0.03 max	22.0-25.0	12.0-14.0	0.7-1.0
-------------	----------	------------	-------------	-------------	-----------	-----------	---------

MECHANICAL PROPERTIES (RANGE) :

Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L=4D)	Charpy V-notch impact strength	
560-600	30	30 min	Temp	Joule
			27° C	50-100

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC (+)	PACKING PER BOX (Pcs)	WEIGHT / 1000 Pcs, Kg.
2.50	350	70-90	100x6=600	21.15
3.15	350	100-120	60X6=360	33.33
4.00	350	120-140	40X6=240	53.13