

GRIBINOX 320LR

IDENTIFICATION

GRIBINOX 320LR E320LR-15

CLASSIFICATION

AWS/SFA 5.4: E320LR-15; BS: 2926: 20.34.2.CuNb.B

DESCRIPTION

Basic coated stainless steel electrode depositing fully austenitic, niobium stabilised weld metal with molybdenum and copper which has a high resistance to corrosion in sulphuric acid, other mineral acids, organic acids and their mixtures. Most parent material specifications are for castings. Deposited weld metal which is fully austenitic, has controlled level of phosphorus and silicon which helps to eliminate solidification cracking tendency.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Cu
0.03 max	1.50 - 2.50	0.3 max	0.015 max	0.02 max	19.0 - 21.0	32.0 - 36.0	2.0 - 3.0	8 x C min Or 0.40 max	3.0 - 4.0

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
520 min	30 min

TYPICAL APPLICATIONS

- Tanks
- Process piping
- Heat exchangers
- Agitators & Rotors, &
- Cast Pump.
- For use in the chemical processing, metal cleaning, & pickling industries

MICROSTRUCTURE

In the as-welded condition, the weld metal microstructure is fully austenitic.

REDRYING : 250°C / 2 hrs

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 80	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	70 - 110	2 x 5 = 10	60 x 5 = 300
4	350	90 - 150	2 x 5 = 10	38 x 5 = 190
5	350	120 - 190	2 x 5 = 10	24 x 5 = 120