

GRITINOX 308 HN

IDENTIFICATION

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DESCRIPTION

A Rutile flux coated electrode designed for welding stainless steel type Outokumpo 253 MA or equivalent. Operability is excellent with a low spatter arc, producing a smooth weld bead surface and self-releasing slag. The deposited weld metal is of X-ray quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	N	Cu	Mo	S	P
0.05 - 0.08	0.6 - 1.0	1.20 - 1.60	21 - 23	10-Nov	0.14 - 0.20	0.75 max	0.75 max	0.03 max	0.04 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
640 - 860	500 - 600	35 - 45	+20°C	60 - 100

TYPICAL APPLICATIONS

For welding high temperature stainless steel, type Outokumpo 253 MA and equivalent ASTM SS 2368, 2362. The weld metal has about 8FN Ferrite which gives high resistance to cracking.

CORROSION RESISTANCE

Excellent resistance to high temperature corrosion.

MICROSTRUCTURE : Austenite with 3 to 10% Ferrite.

REDRYING : 300°C / 2 hrs, max 5 cycles, 10 hr. total.

WELDING POSITION :



PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	50 - 75	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	80 - 120	2 x 5 = 10	60 x 5 = 300
4	350	100 - 160	2 x 5 = 10	38 x 5 = 190
5	350	130 - 210	2 x 5 = 10	24 x 5 = 120