

GRINOX 4L

IDENTIFICATION: GRINOX 4L E308L-16

CLASSIFICATION: AWS/SFA 5.4: E308L-16, BS 2926 E19.9.L.R, DIN 8556 E199 LR26

CHARACTERISTICS:

A medium heavy coated, rutile type AC/DC electrode designed for the welding of low carbon 18%Cr/10%Ni, type 304L, 304 austenitic stainless steel. Operability is excellent with a low spatter arc, producing a smooth weld bead surface and self-releasing slag. The electrode deposits X-ray quality weld metal.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni
0.04 max	0.5-2.5	0.35-0.90	18-21	9-11
Cu	Mo	S	P	
0.75 max	0.75 max	0.03 max	0.04 max	

TYPICAL APPLICATIONS

- For welding ASTM/ASME 304, 304L, 304LN, Cast CF3, CF8, food brewery and chemical process vessels, pipelines and nuclear engineering. Type 301, 302 and 303.
- Also suitable for welding type 321 stabilised stainless steel, petrochemical, power and pharmaceutical industries, paper processing plant.

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN impact strength	
			Temp 0°C	Joules
520 min	380-500	35-45		60-100

CORROSION RESISTANCE:

Good resistance to general and intergranular corrosion. Good resistance to oxidizing acids. Not susceptible to intergranular corrosion.

MICROSTRUCTURE: Austenite with 3 to 9 FN (3-8% Ferrite) Typical 6FN.

ASME IX QUALIFICATION: QW-432 F-NUMBER 5f316, QW-442 A-NUMBER 8

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RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGT (mm)	AMPS AC(70V)/DC (+)	PACKING/BOX (PCS)	WEIGHT/ 1000 Pcs (KGS)
2.50	350	60-80	95X5=475	20.00
3.15/3.20	350	80-100	60X5=300	32.00
4.00	350	110-140	38X5=190	50.00
5.00	350	130-200	25x5=125	80.00

Manufactured by: GEE LIMITED

Regd. Off & Works: plot No.B - 12, MIDC, Kalyan-Bhiwandi Road, Saravli, Kalyan (West) Thane, Maharastra, India.
Website: www.geelimited.com

Authorised Distributor: CROSS MARKETING

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GRICON GREEN NC

IDENTIFICATION: GRICON GREEN NC E 7018-1

CLASSIFICATION: AWS/SFA 5.1: E7018-1, DIN 8529 ESY 4276MU8,
DIN EN 499 E426B42H5 BS639-86 E5143B(24H)

Manufactured by: GEE LIMITED

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Thane, Maharashtra, India.
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