

GRIBINOX 308LT

IDENTIFICATION : GRIBINOX 308LT E308L-15

APPROVED BY: AWS/SFA 5.4: E308L-15; IS: 5206: E 19.9 LB 20

CLASSIFICATION: AWS/SFA 5.4: E308L-15; IS: 5206: E 19.9 LB 20

DESCRIPTION:

A basic coated stainless steel electrode with a controlled composition and low ferrite content, designed for cryogenic service requiring > 0.38 mm charpy lateral expansion at minus 196oC. The electrode has excellent arc stability and low spatter loss. The electrode can be manipulated easily in all welding positions. The deposited welds are of radiographic quality.

TYPICAL APPLICATIONS

- For cryogenic applications involving use of stainless steels types AISI 304, 304L etc.
- Food, Brewery and chemical process vessels pipelines and nuclear engineering.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Cr	Ni
0.04 max	0.50- 2.50	18.0- 21.0	9.0-11.0
Si	S	P	
0.25- 0.55	0.02 max	0.025 max	

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact strength	
			Temp.	Joules
530- 630	390- 480	35-45	-196°C	35-70

ASME SECTION IX QUALIFACTION: QW-432 F-NUMBER, 5, QW-442 A-NUMBER, 8

LATERAL EXPANSION AT-196o C: 0.40 – 0.70 mm

REDRYING: 2500C/2hrs., max 5 cycles, 10 hr. total

RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	AMPS DC (+)	PACKING/BOX (PCS)	WEIGHT/1000 Pcs (KG)
2.50	350	60-100	600	21
3.15	350	90-120	360	32
4.00	350	130-170	240	51
5.00	350	170-240	150	76

Manufactured by: GEE LIMITED

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

Authorised Distributor: CROSS MARKETING

Head Office: Martin Burn Business Park | Suite No 900A | Block- BP | Salt Lake | Sector - V | Kolkata - 700091 | West Bengal | India
Ph: (+91) 9163763419 | (+91) 9038320189
Email: lakhotia.ravi@gmail.com | crossmarketingkolkata@gmail.com