

Austenite + Ferrite Type Electrode (TIG Welding)

G R I N O X 2 9 T

■ Tip Color Green

■ Application

Joint welding between dissimilar steels such as middle and high alloy steel, cast steel, high-manganese steel, spring steel, tool steel)

Overlying on the anticorrosion or heat proof parts such as stamping tool for plastics and rotor.

Underlaying for surfacing of hardened base metals.

■ Features

- GRINOX29T is austenite + ferrite type TIG welding electrode for stainless steel . It is designed so that the contraction stress during cooling stage becomes lower. This characteristics is suitable for underlaying for surfacing on the highly crack sensitive base metal such as alloyed steel.
- The deposited metal has hardenability and shows good anti-shock property. Also because of high content of Cr, the deposited metal shows excellent anticorrosion and heat resistance property.

■ Welding Procedures

- Before start welding, remove grease and blot completely from welding area.
- Keep electric current as low as possible. Also avoid too much weaving. These help reduce welding distortion and dilution from the base metal.

■ Typical Chemical Components of the Electrode (%)

C	Cr	Ni	Others
≤0.12	28.50~31.00	8.30~10.30	Mn, Si, etc.

■ Typical Mechanical Properties of the Deposited Metal as welded

Tensile Strength	N/mm ² (Kgf/mm ²)	745~853(76.0~87.0)
Yield Point	N/mm ² (Kgf/mm ²)	402(41.0)
Elongation	%	≥20
Hardness	HV	265
Hardness after Work Hardening	HV	475
Resistance to Oxidation at High Temperatures		1000°C

■ Dimensions

Diameter (mm)	Length (mm)	Minimum Quantity (kg)
1.6 2.0 2.4 3.2	1,000	5

Equivalent to electrode for shielded metal arc welding: GRINOX29
 Equivalent to wire for MAG welding: GRINOX29S