



310-16

AC/DC+

STAINLESS STEEL

DESCRIPTION

Rutile-basic electrode with a high temperature resistant austenitic stainless steel deposit. Resistant to corrosion and oxidation up to 1200°C (2192°F), good resistance against hot cracks, easy slag removal and nice aspect of the weld beads.

CLASSIFICATION

AWS A5.4 : ~ E310-16 EN 1600 : E 25 20 R 32 ISO 3581-A : E 25 20 R 32

TYPICAL APPLICATIONS

Construction of steam boilers, chemical installations, gas industry, ovens, thermal equipment.

BASE MATERIALS: 310, 310S, 314, 309, HK40

PROCEDURE

Redrying 2h at 250°C if necessary. Avoid prolonged stay at 600-850°C (sigma phase formation). Interpass temperature : < 150°C (300°F)

MECHANICAL PROPERTIES

Tensile strength: > 80 000 psi (550 MPa)
 Yield strength: > 58 000 psi (400 MPa)
 Elongation: > 30 %
 Impact (Charpy V): > 60 J at +20°C

TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Ni	Cr
0.1	2.0	0.90	20.5	25.5

WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")	2.0 mm (5/64")
Amperage:	180 A	135 A	100 A	70 A	45 A

WELDING POSITIONS



1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

Rév. :7_01

Specialized welding alloys and technology. For technical assistance or for ordering:



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