

E310-16

AWS A5.4 E310-16
ISO3581-A-E25 20 R
GB/T 983 E310-16

Description:

An austenitic stainless steel electrode designed to weld 25Cr20Ni steels. The weld metal heat resistance scaling up to 1100-1150°C and does not contain any measurable ferrite. It can also be used to weld certain air hardening steels such as armour plate and joint stainless to unalloyed steels. Used to weld similar composition heat resistance stainless steels, high hardenability chromiums steels and dissimilar steels.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	605
Yield strength(MPa):	--
Elongation(%):	40

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.12	1.35	0.02	0.003	0.58	21.5	26.5	0.32	0.12

Welding Current:(AC/DC±)

Diameter(mm)	2,5	3,2	4,0	5,0
Current/A	F/H 60-80	80-120	100-150	140-180
Current/A	V/OH 40-70	60-100	80-130	-

Note:

- 1.The electrodes should be baked 1 hours in 300-350°C before using.
- 2.Welding in short arc,and swing scope should not excess 2.5 times of the electrode diameter.