CODING:

EURO 310-15

AWS E 310-15

CHARACTERISTICS:

A medium heavy coated basic type all-position electrode made from 25Cr/20Ni core wire to give 25/20 weld deposit which has excellent stability and oxidation resisitance up to 1150°C **.**

TYPICAL APPLICATIONS:

Welding AISI 310 type, German steels 4762,4828,4841,4846 and 4848, cladding side of stainless clad steels, straight chroma steels and dissimiliar steels, hydrogenation and polymerization plant, gas turbine combustion chamber parts, high temp furnace parts, annealing boxes and carburizing pots.

SPECIAL INSTRUCTIONS FOR WELDING:

- Keep electrodes dry.
- Do not exceed recommended current limit.
- Hold short arc. Ensure good fit-up on joints.
- Adopt proper sequence.
- Remove the slag with a stainless steel wire brush.

CURRENT CONDITIONS:

SIZE mm		2.50X350	3.15 X 350	4.00 X 350	5.00 X 350
CURRENT - Amps	AC70/DC(+)	50-75	80-100	110-140	150-180

CHEMICAL ANALYSIS OF THE WELD METAL :

Element	**C**	**Cr**	**S**	**Ni**	**Mn**	**Si**	**P**
%	0.05 – 0.12	25-28	0.03max	20-22	1.0-2.5	0.20-0.45	0.03max

TYPICAL MECHANICAL PROPERTIES OF WELD METAL

UTS N/ mm^2	ELONGATION(%)(J) Charpy –V impact value at -196°C
560-660	35-65