

SMAW

For Stainless Steel

STAINARC 310

CLASSIFICATION : AWS A5.4 E310-16

JIS Z3221 D310-16

WELDING POSITIONS :



- 25 Cr / 20 Ni Type Stainless Steel Electrode
- Heat Resisting, Fully Austenitic Weld Deposit
- Resists Scaling At Temperatures Up To 1050°C

DESCRIPTION AND APPLICATIONS

STAINARC 310 is a rutile / basic type stainless steel electrode depositing heat resisting 25% Cr / 20% Ni type weld metal. As the weld metal is fully austenitic, it resists scaling at temperatures up to 1050°C. The smooth arc of the STAINARC 310 gives exceptional weldability in all positions, promotes good weld appearance, weld shape, low spatter and easy slag removal. Other features include easy restrike and the ability of the electrode to be used on low open circuit voltage AC welding machines. Excessive amperages, eg. heat input, should be avoided to prevent the risk of hot cracking in the weld metal.

STAINARC 310 is recommended for welding heat resisting steels of the 25% Cr / 20% Ni type, eg. 310, used as parts of heat treatment and case hardening furnaces, cement kilns and burners subjected to high temperature oxidation in non-sulphurous atmospheres.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Ni	Fe
0.08	2.0	0.4	26.0	20.0	Bal

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES*

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
405 N/mm ²	550 N/mm ²	>30%	70J @ + 20°C

- in "as welded" condition.

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	PACKAGING (kg)		
			PKT	CTN	
2.6	300	50 - 80	2.5	5	20
3.2	350	65 - 100	2.5	5	20
4.0	350	90 - 130	2.5	5	20

- Recommended for DC + or AC (minimum 55 OCV) operation

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