

# 310

## SPECIAL WELDING ROD FOR STAINLESS STEEL TYPE AISI-310 FOR SURFACING AND REPAIR OF PARTS SUBMITTED TO SEVERE CORROSIVE AND HIGH TEMPERATURE CONDITIONS.

CLASSIFICATION A.W.S: E-310-16

**APPLICATIONS:** To weld stainless steel when its composition is unknown. For applications in the chemical industry, in the oil refinery industry and in the food processing industry. For welding and as surface preparation for cladding in steel with high manganese content.

**CHARACTERISTICS AND PROCEDURE:** E-310 is an austenitic stainless steel welding rod with a special covering for applications on high temperature resistant steel like 309,310,316,321,347 and 410. With this electrode you have a solution for hard to weld high carbon steel of up to 0.05% carbon content. It is also used with low alloy steel, including those with 4 to 6% Chromium content (AISI-502), specially when postweld heat treatment is not feasible. It is used to join different steel alloys, too. This welding rod offers top reliability to join metals and to deposit its filler metal is easy. Clean the area of the joint to remove dirt, scales, grease and rust. Use reverse polarity. Keep the arc short. Do not let the welding rod contact the surface. Tilt the electrode slightly towards the weld direction. Make stringer beads (straight) with no swings. For vertical welding, use sizes up to 4 mm (5/32") at low amperage. Remove slag between one pass and the next.

<b>TENSILE RESISTANCE:</b>	6,327 KG./CM2 (90,000 PSI)
<b>BRINELL HARDNESS:</b>	205 (RC-16)
<b>ELONGATION:</b>	40%
<b>FERRITE No.:</b>	0
<b>POSITIONS:</b>	ALL
<b>CURRENT:</b> :	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>	<b>Ni</b>	2.38 mm-3/32"	50-70
0.15	1.80	0.75	26.0	21.0	3.25 mm - 1/8"	80-100
					4.0 mm - 5/32"	110-130
					5.0 mm - 3/16"	140-170