

310Cb

SPECIAL WELDING ROD FOR STAINLESS STEEL TYPES AISI-310 Cb, 310, 347 AND 321, FOR CARBON STEEL AND FOR ALLOY STEEL. .

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

APPLICATIONS: To weld stainless steel with a similar composition or when the composition is unknown. Its high Chromium Nickel content makes it suitable for severely corroding environments. It is ideal to be used in the chemical industry. It is recommended to weld stainless steel types 410, 430 and 502. The resulting filler metal is very elastic and pre and postweld heating are unnecessary. Its Columbium content acts as a stabilizing element to avert inter granular corrosion. This electrode is outstanding for its high corrosion and oxidation resistance at very high temperatures up to 1,200°C. It is suitable to weld parts in furnaces, in the production and cladding of crucibles, heat exchangers, nitriding and carburizing boxes, turbines, boilers, distillery equipment, reactors, the oil refinery and chemical industry, the paper industry, etc.

CHARACTERISTICS AND PROCEDURE: Filler metal has a good resistance to corrosion and is free of carbide precipitation. Clean the joint area to remove dirt, scales, grease and rust. Use reverse polarity. Keep the arc short and do not let the welding rod contact the surface. Tilt the welding rod slightly in the direction of the weld. Make stringer beads (straight) with no swings. For vertical welding use sizes up to 4 mm (5/32") at low amperage. Remove the slag between one pass and the next.

TENSILE RESISTANCE :	6,327 KG./CM2 (90,000 PSI)
BRINELL HARDNESS:	205 (RC-16)
ELONGATION:	35%
FERRITE No.:	0
POSITIONS:	ALL
CURRENT:	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %						SIZES	AMPERAGE
C	Mn	Si	Cr	Ni	Cb		
0.11	1.80	0.75	26.0	21.0	0.80	2.38 mm - 3/32"	50-70
						3.25 mm - 1/8"	80-100
						4.0 mm - 5/32"	110-130
						5.0 mm - 3/16"	140-170