

spark 310

Heat resistant Stainless Steel Welding Electrode

Classifications: AWS A5.4: E310 –16 || IS5206: E 25.20LR26

Descriptions: A rutile - basic type 25 Cr - 20 Ni, heat resistant electrode with resistance to oxidation upto 1150°C. The austenitic stainless steel electrode possesses features like smooth arc, low smoke-spatter and excellent slag detachability.

Applications:

- Welding high temperature furnace parts, cladding side of stain less clad steels.
- Extensive uses in polymerization plants, annealing boxes, carburizing pots, gas turbine combustion chambers.
- High temperatures chutes for hot sinter, slag granulation ducts, blast furnace overburden probes etc.
- Welding stainless to low alloy and harden-able dissimilar steels etc.

Welding Parameters:

Size (mm X mm)	Current (Amps)
2.50 x 350	55-80
3.15 x 350	75-110
4.00 x 350	120 - 160

Typical Mechanical Properties:

UTS	580 N/mm ²
Elongation	36%
Yield Strength	390 N/mm ²

Typical All weld metal composition (%):

C	Mn	Si	Cr	Ni	S	P
0.09	1.7	0.7	26.4	20.8	0.016	0.027