S-310.16

TYPE : Rutile

AWS A5.4 / ASME SFA5.4 E310-16
JIS Z3221 ES310-16
EN 1600 - E 25 20 R

Applications

Welding of 25%Cr-20%Ni stainless steel.
Fabrication and repair of furnace linings, furnace grates, burners.

Characteristics on Usage

S-310.16 is a lime-titania type electrode, all-weld metal has fully austenite structure.
Excellent in heat resistance, corrosion resistance and mechanical properties due to stable of fully austenitic microstructure.

Notes on Usage

① Dry the electrodes at 350℃(662℉) for 60 minutes before use.
② Keep the arc as short as possible.

Welding Position

1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni
0.10	0.60	1.90	0.018	0.013	26.5	20.6

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in²)	EL (%)
610 (88,400)	35.0

Approval

I Packing

Packet 2.5 ㎏ (5.5 lbs)
Carton 2.5 ㎏ (5.5 lbs)×4 : 10㎏(22 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F	30~55	40~80	70~115	95~150	140~180
V-up, OH	25~50	35~75	65~110	90~145	-