

An advanced electrode for quality welding of stainless steel types AISI 310 and equivalent grades

Typical Application:

For welding heat resistant steels of type 25Cr-20Ni such as AISI 310. Also used for Dissimilar welding of Carbon Steel to Stainless steel & joining applications in gas turbine combustion chamber components, high temperature furnace parts and joining of Boiler quality Steel to SS 310.

Outstanding Features:

- Ideal for oxidation and heat resistance.
- Ideal for joining unknown stainless steel.
- Smooth, rapid, spatter-free deposition.
- Confirms to ASME Sec II, Part C, SFA 5.4, Class E 310-16.

Characteristics:

Precisely controlled chemistry of the alloyed core wire and the flux coating enables consistent weld metal properties.

Procedure:

Clean weld area. Tack at short intervals when jigs are not available. Square butt weld thickness upto 10 gauge. Heavier section should be bevelled 60 Deg. Maintain short arc and deposit stringer beads. Avoid weaving.

Technical Characteristics:

Typical All-weld Chemistry (Wt %)

C	Mn	Si	Cr	Ni	S	P	Mo
0.15	1.80	0.50	26.00	21.00	0.02	0.03	0.2

Typical All-weld Mechanical Properties:

Tensile strength :580 Mpa

Elongation (L = 4D) :33%

Recommended Amperages (DC+, AC 70V):

Size (mm)	2.5	3.15	4.0	5.0
Amps	60-80	85-140	115-140	145-180



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