

ROWELD- 310

RUTILE TYPE 25CR/20NI FULLY AUSTENITIC STAINLESS
STEEL ELECTRODE

BASIC ALLOY: MN, CR, NI
AWS/SFA-5.4: E310-16
EN ISO 3581- A E 25 20 R 32

KEY FEATURES:

A rutile type all position electrode made of core wire 25Cr/20Ni to have deposits of 25Cr/20Ni. The electrode is specially designed for oxidation and scaling resistance at elevated temperatures at 1200°C with excellent weld metal finish, low spatter and easily removable slag deposit.

APPLICATIONS

- Suitable for weld AISI 310 type steel and DIN Nr. 1.4848, 1.4841, 1.4845
- German steels like 4762,4828,4841,4846 and 4848
- Clad side of clad steels
- High temperature furnace part
- Gas turbine combustion chambers
- Hardenable steel and dissimilar steels

RE-DRY CONDITION:

- Re-Dry the electrode at 250°C for one hour before use.

CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Cr	Ni
0.08-0.20	1.00-2.50	0.75 Max	0.030 Max	0.040 Max	25.00-28.00	20.00-22.50

MECHANICAL PROPERTIES:

UTS (N/mm)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @	FERRITE (FN)
520-660	35-45	+2C : 60-100 J	Nil

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+ / AC) Amps	Kg/pkt.	Kg/Case
2.50 / 2.40	3 / 32"	60-90	2	20
3.15 / 3.20	1 / 8"	80-110	2	20
4.00	5 / 32"	100-135	2	20
5.00	3 / 16"	140-180	2	20