S-310.15

Type : Basic(Lime)

Conformances

AWS A5.4/ ASME SFA5.4 E310-15

JIS Z3221 ES310-15

EN ISO 3581-A-E 25 20 B

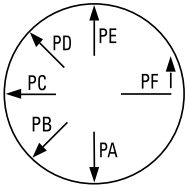
Applications

- Welding of 13%Cr or clad part of 18%Cr-8%Ni steel

Features

- Basic type electrode
- Good mechanical properties
- Martensite structure (All-weld metal)

Welding Position



Current

DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter	Length	P.V.C	
mm (in)	mm (in)	packet	carton
		2.5kg(5.5lbs)	10kg(22lbs)
2.6 (3/32)	350 (14)	√	
3.2 (1/8)	350 (14)	√	
4.0 (5/32)	400 (16)	√	
5.0 (3/16)	400 (16)	√	
6.0 (15/64)	450 (18)	√	

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

Typical Welding Parameters / Amp.(A)

Diameter 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 & HF	25~55	50~85	70~115	95~145	135~180
V-up, OH	20~50	45~80	65~110	85~135	-