

Stick Electrode for Stainless Steel

KS-310HC

Classification

AWS A 5.4/A5.4M	E310H-16
JIS Z3221	ES310H-16
EN 3581-A	E 25 20 H R
GB T 983	E310H-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is high carbon with 25%Cr-20%Ni.
- (2) It provides high strength at high temperature due to high carbon content.
- (3) It also provides good heat resistance.
- (4) It is ideal for welding or repairing AISI 310 and similar grade steel castings at high temperature.

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For welding dissimilar metals, please refer to Appendix I.
- (3) For other instructions and information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni
0.420	0.68	1.64	0.013	0.008	26.70	20.46

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %
780(79.5)	630(64.2)	18

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.0x250	2.6x300	3.2x350	4.0x350	5.0x350
Amp	F/H-Fillet 35~55	50~85	80~120	100~150	140~200
	V-up/OH 30~50	45~85	70~110	90~135	—