

## COVERED ELECTRODES FOR STAINLESS STEEL

### DESCRIPTION & APPLICATIONS :

- SS-310 is a titanium oxide low hydrogen electrode, the weld metal contains 25%Cr-20%Ni the austenitic structure.
- It is suitable for high temp. furnace, the AISI 310, and SUS 310S welding.

### NOTE ON USAGE :

- Rebake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100~150°C prior to use.
- With lower current is to properly keep the dilution of the parent metal for welding crack.

### WELDING POSITION :



### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

| C    | Mn   | Si   | P     | S     | Ni    | Cr    |
|------|------|------|-------|-------|-------|-------|
| 0.11 | 1.75 | 0.28 | 0.028 | 0.001 | 21.23 | 26.50 |

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

| TENSILE STRENGTH<br>N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> ) | ELONGATION RATE<br>% |
|--------------------------------------------------------------|----------------------|
| 594(60.6)                                                    | 36                   |

### SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

| Diameter (mm)    |        | 2.6   | 3.2    | 4.0     | 5.0     |
|------------------|--------|-------|--------|---------|---------|
| Length (mm)      |        | 300   | 350    | 350     | 350     |
| Current<br>(Amp) | F      | 50-85 | 80-120 | 100-150 | 140-180 |
|                  | V & OH | 45-80 | 70-110 | 90-135  | -       |