

## SB ZULFI E 310-15

### Brand Name & Classification

AWS/ASME SFA-5.4: E 310-15  
DIN 8556: E 25 20 B 20  
EN 1600: E 25 20 B 42

### Approvals Grade

### Properties

Electrode for welding of heat resistant chromium and chromium-nickel steels or cast steels. Fully austenitic weld metal, non scaling up to +1200° c. Weld metal is not resistant to sulphurous combustion gases.

### Application

1.4745: G-X 40 CrSi23 1.4837 G-X 40CrNiSi 25 12  
1.4823: G-X 40 CrNiSi 27 4 1.4840: G-X 1 CrNi 25 20  
1.4832: G- X 25 CrNiSi 20 14 1.4841: X 15 CrNiSi 25 20  
1.4833: X 7 CrNi 23 14 1.4845: X 12 CrNi 25 21

### Weld Metal Analysis Typical values

Carbon: 0.10

Silicon: 0.50

Manganese: 4.50

Chromium: 25.0

Nickel: 20.0

### Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>400 N/MM2	550 - 620 N/mm2	> 35 %	100 J at +20° c

### Welding Current & Positions



### Current

Dia	Length	Amperes
2.5	300	45-80
3.2	350	70-120
4.0	350	100-150