Supranox E 310

شركة مصنع الزلفي لاسلاك اللحام المحدودة
Zulfi Welding Electrodes Factory Co. LTD

Brand Name & Classification

AWS/ASME SFA-5.4: E 310-16
DIN 8556: E 25 20 R 23
EN 1600: E 25 20 R 23

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 +1200^0 c. Weld metal is not resistant to sulphurous combustion gases.

Application

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

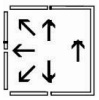
Weld Metal Analysis Typical values

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 +20^0 c

Welding Current & Positions



Current

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