



Inox 310H (DC+)

STAINLESS STEEL

DESCRIPTION

Basic coated austenitic stainless steel electrode with 26%Cr, 21%Ni and an increased carbon content. Used to weld austenitic heat resistant alloys, centrifugally cast tubes etc. resisting to scaling and oxidation up to 1100°C. Regular and stable fusion, good slag removal, nice aspect of the bead.

CLASSIFICATION

AWS A5.4 : E310H-15 EN 1600 : E 25 20 H B 4 2 ISO 3581-A : E 25 20 H B 4 2

TYPICAL APPLICATIONS

Petrochemical industry, for furnaces, reformer and steam cracker tubes, piping systems.

BASE MATERIALS

UNS	Alloy	EN	Material N°
J93503		G-X40CrNiSi25-12	1.4837
J94204	HK 40	G-X40CrNiSi25-20	1.4848

PROCEDURE

Redrying 2h at 250°C if necessary. Interpass temperature : < 150°C (300°F)

MECHANICAL PROPERTIES

Tensile strength: > 94 274 psi (650 MPa)
 Yield strength: > 65 266 psi (450 MPa)
 Elongation: > 15 %

TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Mo
0.4	2.0	0.7	26.0	21.0	0.2

WELDING PARAMETERS

Diameter: 4.0 mm (5/32") 3.2 mm (1/8") 2.5 mm (3/32")
 Amperage: 125-145 A 90-110 A 60-80 A

WELDING POSITIONS



1G/PA

2F/PB

2G/PC

3G/PF

4G/PE

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