

AK E310-16

Description: An austenitic stainless steel electrode designed to weld 25Cr20Ni sheets of steel. The weld metal heat resistance scales to 1100- 1150°C and does not contain any measurable ferrite. It is used to weld certain air-hardening steels such as arm plates and joint stainless to unalloyed steels.

Application: Used to weld similar composition heat resistance stainless steels, high harden ability chromiums steels, and dissimilar steels.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.08-0.20	0.75	1.0-2.5	0.03	0.03	20.0-22.5	0.75	25.0-28.0	0.75
Actual Result	0.12	0.58	1.35	0.0032	0.02	21.5	0.32	26.50	0.12

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 550		≥25	
Actual Result	605		40	

Recommended welding parameters:

Diameter/mm		2.5	3.2	4.0
Welding current/A	F/H	60-80	80-120	100-150
	V/ OH	40-70	60-100	80-130