

AK E310Mo-16

Description: AK-E310Mo-16 is a rutile type coated Cr26Ni21Mo2 pure austenitic stainless steel electrode. AC and DC dual-use, can perform all-position welding. The electrode has good welding process performance. Because of the addition of molybdenum to the deposited metal, the corrosion resistance, heat resistance and crack resistance are improved compared with A402 and A407.

Application: It is used for welding the same type of heat-resistant stainless steel that works under high temperature conditions, and can also be used for welding stainless steel linings, dissimilar steels, etc. Excellent toughness when welding carbon steel and low alloy steel with high hardenability.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.12	0.75	1.0-2.5	0.03	0.03	20.0-22.0	2.0-3.0	25.0-28.0	0.75
Actual Result	0.09	0.30	2.08	0.010	0.025	21.22	2.29	26.21	0.08

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 550		≥25	
Actual Result	605		37	

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