

Stick Electrode for Stainless Steel

KS-310

Classification

AWS	A 5.4	E310-16
JIS	Z3221	ES310-16
EN	3581-A	E 25 20 R
GB	T 983	E310-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 25%Cr-20%Ni.
- (2) It is suitable for welding AISI 310 and AISI 310S.

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For welding dissimilar metals, please refer to Appendix I.
- (3) For other instructions and information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni
0.110	0.40	1.90	0.010	0.010	27.30	21.07

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %
590(60.2)	410(41.8)	39

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.0x250	2.6x300	3.2x350	4.0x350	5.0x350	
Amp	F/H-Fillet	35~55	50~85	80~120	100~150	140~200
	V-up/OH	30~50	45~85	70~110	90~135	—