

## Stick Electrode for Stainless Steel

# KS-310Mo

### Classification

AWS	A 5.4/A5.4M	E310Mo-16
JIS	Z3221	ES310Mo-16
EN	3581-A	—
GB	T 983	E310Mo-16

Type of coating: Lime titania type

### Applications and Features

- (1) Weld metal is 25%Cr-20Ni%-2%Mo.
- (2) It is suitable for welding heat resistant steel castings, AISI 316 and build-up on carbon steel.

### 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	Mo
0.100	0.46	1.68	0.015	0.010	26.84	21.06	2.42

### Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	%
590(60.2)	430(43.8)	36

### 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	—