



D&H 310Mo

CODIFICATION : AWS : SFA 5.4 E310Mo-16

CHARACTERISTICS AND APPLICATIONS:

A stainless steel electrode depositing 25Cr - 20Ni - 2.5Mo weld metal. It possesses excellent mechanical properties and resists at high temperatures. The electrode is suitable for welding of heat resisting castings, type 316 clad steels and overlay of carbon steels.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	C	Mn	Si	S	P	Cr	Ni	Mo
Percent	0.06	2.10	0.50	0.015	0.020	26.8	20.5	2.4

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L = 4d) %
600	32.0

CURRENT & PACKING DATA : AC / DC(+)

Size (mm)	: 5 x 350	4 x 350	3.15 x 350	2.5 x 350
Dia x Length				
Current Range (Amps)	: 150-180	110-140	80-110	60-80
Weight / Carton (kgs)	: 2.5	2.5	2.5	2.5

PRECAUTIONS :

1. Re-dry the electrodes at 250-300°C for one hour for best results.
2. Use low current short arc and minimum weaving.