MIDALLOY CHROMAX E310-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E310-16 / ASME SFA 5.4 Class E310-16
- UNS W31010
- ASME A#9 F#5

DESCRIPTION

- MIDALLOY CHROMAX E310-16 is AC-DC Titania Coated Electrode
- Completely austenitic microstructure (no ferrite)
- Welding parameters must be optimized to avoid hot cracking

APPLICATION

- Welding type 310 stainless steel
- Welding carbon steel to stainless steel
- For welding or repairing high alloy head and corrosion resistant castings of the same general composition.

TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N
.14	27.0	20.4	.10	1.30	.45	.015	.005	.08	.06

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	89,900 PSI
ELONGATION IN 2”	38%
HEAT TREATMENT	NONE

WELDING PARAMETERS

DIAMETER	VOLTAGE	AMPERAGE	
		FLAT	VERTICAL & OVERHEAD
3/32”	24-28	70-85	65-75
1/8”	26-30	85-110	80-90
5/32”	28-32	110-140	100-120
3/16”	28-32	120-160	110-130

STANDARD PACKAGING

- 3/32” 8 lb. can / 48 lb. carton
- 1/8” 10 lb. can / 60 lb. carton
- 3/16” 10 lb. can / 60 lb. carton
- 5/32” 10 lb. can / 60 lb. carton

8/3/11

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Midalloy