



E310-16

DESCRIPTION: Weldcote Metals E310-16 electrodes are used to weld stainless steels of similar composition in wrought and cast form. The weld deposit is fully austenitic, and as such calls for minimum heat input during welding.

APPROVALS: Manufactured under Quality System approved by ASME, IS09001. Meets AWS 5.4 Class E310-16.

CHEMICAL COMPOSITION

Carbon	.11
Manganese	1.90
Silicon	.52
Chromium	26.2
Nickel	20.95
Sulfur	.012
Phosphorus	.016
Iron	Balance

MECHANICAL PROPERTIES

Tensile Strength

90,500 PSI 625 MPA

Yield Strength

61,500 PSI 425 MPA

Elongation

34%

WELDING PARAMETERS

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.