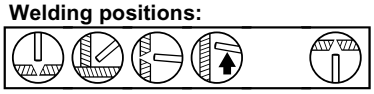
Cromarod 310

SMAW - (Stick) - MMA
Stainless Steel

Date: 2002-06-18
Revision: 15

Description:
Cromarod 310 is a rutile coated electrode primarily intended for welding the 25%Cr / 20%Ni, type 310, fully austenitic stainless steels, used for corrosion and oxidation resistance at elevated temperatures. Cromarod 310 can also be used to join difficult-to-weld steels such as armour plate and ferritic stainless steels, as well as dissimilar steels. Although the weld metal is fully austenitic the composition has been carefully balanced to give good resistance to hot cracking.

Welding positions:



Coating type:
Rutile

Welding current:
DC +, AC 0CV > 39V

Ferrite content:
FN 0 (WRC-92)

Corrosion resistance
Cromarod 310 is designed for high temperature oxidation applications and its resistance to wet corrosion is limited.

Scaling temperature:
Approx. 1150°C in air. Reducing combustion gas, free of sulphur 1080°C, maximum 2g S/m3 1040°C.

Redrying temperature:
350°C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min	0,06	0,5	2,0			25,0	20,0
Typical	0,10	0,8	2,4	0,02	0,02	26,6	21,3
Max	0,20	1,2	3,0	0,030	0,025	27,0	22,0

	Mo	Cu	V	Nb
Min				
Typical	0,1			
Max	0,5	0,5	0,1	0,1

Mechanical properties

	Specified	Typical
Yield strength, Rp0.2%:	≥ 350 N/mm²	410 N/mm²
Tensile Strength, Rm:	≥ 560 N/mm²	600 N/mm²
Elongation, A5	≥ 30%	35%
Impact energy, CV:		-60°C • 60 J

Classification:

EN 1600-97	~E 25 20 R 12
AWS A5.4-92	~E 310-17
BS 2926-84	~25.20 R
DIN 8556-86	E 25.20 R 23
NF A81-343-79	~EZ 25.20 R 23

Approvals:
UDT
DNV
INSPECTA
SVK

Note

AWS: Slight deviation in Mn.
BS: Slight deviation in Si.

Core wire:
P ≤ 0.030%
S ≤ 0.030%
N ≤ 0.050%

Product data

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/kg electrodes	No. of electrodes/kg weld metal	Kg weld metal/hour arc time	Burn-off time/electrode (sec.)
2,50	300	74362500	40-80	25	0,64	83	1,0	37
3,25	350	74363200	80-120	26	0,64	45	1,3	56
4,00	350	74364000	130-170	29	0,64	30	1,9	59