

GRINOX 310Mo

IDENTIFICATION

GRINOX 310Mo E310Mo - 16

CLASSIFICATION

AWS A 5.4: E 310Mo - 16

DESCRIPTION

An extruded, rutile based heavy coated electrode for welding 25/20 Chromium Nickel Stainless Steel.

WELD METAL ANALYSIS (RANGE) %

C	Mn	S	P	Cr	Ni	Mo	Cu	Si
0.12 max	1.0 - 2.5	0.03 max	0.03 max	25.0 - 28.0	20.0 - 22.0	2.00 - 3.00	0.50 max	0.75 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
550 min	30 - 40	0°C	70 - 120

TYPICAL APPLICATIONS

Weldable in all positions. The weld bead is finely-rippled, smooth, and regular. The deposit is highly resistant to cracking. Scale resistance upto 1000oC. The deposited weld metal is of radiographic quality.

TYPICAL APPLICATIONS

- For joining the above heat resisting steels and also for surfacing unalloyed, low/high alloy and cast steels. Furnace fabrication, apparatus, steam boilers, piping & fittings, textile, paper, paint, rubber and glass industries, heat treatment shops, gas turbines, oil refineries, furnace fabrication, etc.
- Overlay on castings.
- Welding of heat resisting castings.
- Highly stressed corrosion-resistant Stainless steel containing about 25% Chromium & 20% Nickel. Also for Stainless Steel AISI grades 309 & 310 and clad steels. Also used for joining dissimilar steels, straight Chromium Steels, welding intermediate zones between mild steel and Stainless Steels, joining difficult alloy/High Carbon Steels.

WELDING PROCEDURE : The base metal should be free from oil, Grease or Dirt before welding. Keep a short arc - length. The weld bead should be cleaned with stainless steel brush.

FERRITE NUMBER OF THE WELD : 0

WELDING POSITION :



1G 2F 2G 3G 4G 5G

PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC 70 (OCV) / DC (+)	Packing / Box (kg)	Packing / Box (Pcs)
2.5	350	60 - 90	2 x 5 = 10	94 x 5 = 470
3.15 / 3.20	350	80 - 110	2 x 5 = 10	60 x 5 = 300
4	350	110 - 140	2 x 5 = 10	38 x 5 = 190
5	350	140 - 180	2 x 5 = 10	24 x 5 = 120