

# **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) %



### **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** : O

### WELDING POSITION :



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# **GWELD** PÁČKÍŇG PAŘAMETERS

Size (mm)	Length (mm)	AMPS	Packing / Box (kg)	Packing / Box (Pcs)
		AC 70 (OCV) / DC (+)		
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