GWELD
SEAL OF TRUST

GRITINOX 310

IDENTIFICATION
GRITINOX 310 E310-17

CLASSIFICATION
AWS A 5.4: E 310–17
IS : E 25.20 R 26 X DIN 8556 E25.20R 23

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

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.08 - 0.16	1.0 - 2.5	0.50 - 0.90	0.03 max	0.03 max	25.0 - 28.0	20.0 - 22.50	0.75 max	0.50 max

MECHANICAL PROPERTIES (RANGE)

TS (N/mm2)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
560 - 660	30 - 40	27°C	70 - 120

WELDING PROPERTIES

Weldable in all positions. Arc striking and re-striking properties are excellent. Arc is soft & stable. The spatter is very low and the slag is easy to remove. 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. 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 :

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