STARINOX 310

TOP FEATURES

- Fully austenitic microstructure containing 25%Cr and 20%Ni, non-scaling <1150°C, but not resistant to sulphurous gases.
- Excellent weldability, with a spatter free arc and self-releasing slag, combined with a very smooth bead appearance
- Very smooth bead appearance

CLASSIFICATION

AWS A5.4	E310-16
EN ISO 3581-A	E 25 20 R 12

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

CE
+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni
0.1	1.7	0.6	27	21

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.4	AW	not specified	≥550	≥30	not specified
EN ISO 3581-A	AW	≥350	≥550	≥20	not specified
Typical values	AW	≥350	≥550	≥30	≥60

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	50-90
3.2 x 350	80-110

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	100	2.1	W100258707
3.2 x 350	VPMD	60	2.0	W100258708

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.