

Stainless Steel Electrodes

Alloy: WW310-16 Class: E310-16

Conforms to Certification: AWS A5.4 ASME SFA A5.4

Alloy: E310-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.08 – 0.20	Si = 0.75 max
Cr = 25.0 – 28.0	P = 0.03 max
Ni = 20.0 – 22.5	S = 0.03 max
Mo = 0.75 max	Cu = 0.75 max
Mn = 1.0 – 2.5	

Deposited All Weld Metal Properties %  
(Typical) As-Welded

Yield Strength	90,500psi
Tensile Strength	61,500psi
Elongation	34%

Deposited Chemical Composition % (Typical)

C = 0.11	Si = 0.52
Cr = 26.20	P = 0.016
Ni = 20.95	S = 0.012
Mn = 1.90	

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

<u>Diameter</u>	<u>Voltage</u>	<u>Amperage Flat Position</u>	<u>Amperage Vertical &amp; Overhead</u>
3/32	24-28	70-85	65-75
1/8	26-30	85-110	80-90
5/32	28-32	110-140	100-120
3/16	28-32	120-160	110-130

Application

E310-16 electrodes used to weld stainless steels of similar composition in wrought and cast form. The weld deposit is fully austenitic, and requires minimum heat input during welding. It is considered a general purpose electrode for welding almost every analysis of carbon and alloy steels. If welding dissimilar metals use 300°F min preheat

