

Stainless Steel Electrodes

Alloy: WW310H-16 Class: E310H-16

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

Alloy: E310H-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.35 – 0.45	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	102,000psi
Tensile Strength	86,000psi
Elongation	12%

Deposited Chemical Composition % (Typical)

C = 0.41	Si = 0.52
Cr = 26.25	P = 0.019
Ni = 21.40	S = 0.021
Mn = 2.15	

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 & 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

E310H-16 electrodes are used to weld high alloy heat and corrosion resistant castings. This electrode is not recommended for service in high sulfur atmospheres.

