

BASINOX 310 is a basic coated electrode for welding identical/similar heat-resistant steels and cast steel, <1150°C.

Suitable for the welding of AISI 310 and heat resistant alloys. Typical applications are in fluidised bed combustors, kilns, radiant tubes, tube hangers for petroleum refining and steam boilers, burners and combustion chambers.

The electrode deposits fully austenitic weld metal containing 25%Cr and 20%Ni.

Slag solidifies quickly, covers the weld uniformly and BASINOX 310 is well-suited for positional welding.

Classification

EN	3581-A: E 25 20 B 22
AWS	A5.4: E 310-15

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni
0.09	2.0	0.7	≤0.03	≤0.02	26	20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
As Welded	≥ 400	≥ 550	≥ 30	≥ 60

Materials

AISI 310; 1.4845 (X8CrNi25-21); 1.4841 (X15CrNiSi25-21); 1.4828 (X15CrNiSi20-12)

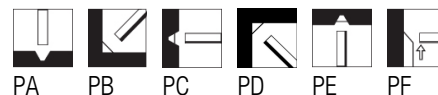
Storage

Keep dry and avoid condensation.

Re-dry at 250-300 °C for 1 hour, 5 times max.

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	VPMD	
				PC	Code
2.5	300	50-80	18.95	95	W000380564
3.2	350	70-110	35.0	60	W000380565
4.0	350	110-140	52.50	40	W000380566
5.0	350	130-180	83.37	25	W000380567