

SUPRANOX RS 310 is a rutile coated electrode for welding identical/similar heat-resistant steels and cast steel. 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. Fully austenitic microstructure containing 25%Cr and 20%Ni, non-scaling <1150°C, but not resistant to sulphurous gases. This electrode is an optimum for weldability, with a spatter free arc and self-releasing slag, combined with a very smooth bead appearance.s. For thick-walled components, the basic coated BASINOX 310 is recommended.

### Classification

EN	3581-A: E 25 20 R 12
AWS	A5.4: E 310-16

### Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni
0.1	1.7	0.6	27	21

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
As Welded	≥ 350	≥ 550	≥ 30	≥ 60

### Materials

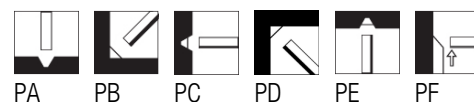
AISI 310; 1.4845 (X8CrNi25-21); 1.4841 (X15CrNiSi25-21); 1.4828 (X15CrNiSi20-12)

### Storage

Keep dry and avoid condensation.  
Re-drying not generally required.  
If necessary: 250-300°C for 2 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	50-90	18.7	90	W000258439
3.2	350	80-110	36.1	55	W000258440
4.0	350	100-130	53.7	35	W000258441