SUPRANOX 310

CE

MMA Electrodes
Stainless and Heat resistant steels

Rutile coated MMA electrode for welding identical or similar heat resistant steels. Fully austenitic microstructure, non-scaling <1150°C, but not resistant to sulphurous gases. SUPRANOX 310 is an optimum choice for weldability, weld bead profile and weld metal properties. For thick-walled components, the basic coated BASINOX 310 is recommended.

Classification	
EN	1600: E 25 20 R 1 2
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: 300-350 °C for 2 hour, 5 times max

Current condition and welding position

AC; DC+

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		VPMD	
				PC	Code	PC	Code
2.5	300	60-80	18.7	185	●	85	●
3.2	350	80-110	36.1	115	●	55	●
4.0	350	100-130	47.2	100	●	45	●