

Inweld 310-16

AWS A5.4 E310-16

Chemical Composition of Inweld 310-16

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.08	25.0	22.0	0.75	1.0-2.5	0.75	0.03	0.03	---	0.75
	-0.020	-28.0	-22.5							

Single values are maximum unless otherwise specified.

Description and Applications

Designed for All-Position welding on 25% Chrome - 21% Nickel stainless steel such as AISI 310, however it is ideal for joining and overlaying dissimilar steels such as stainless to carbon and low alloy steel as well as to air hardening and armor steel. Produces high strength, heat and corrosion resistant weld deposits at temperatures up to 2150°F. Excellent choice for steels with high impact strength at subzero temperatures as low as -310°F. Common applications involve parts subjected to wear and impact in high temperature applications such as valves, converters, heat exchangers, reactors, chemical and oil industries. Other uses include rebuilding of pumps and shafts.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	80,000 psi
Yield Strength:	60,000 psi
Elongation:	30%

Recommended Parameters

SMAW (ACDC Electrode Positive)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
1/16"		15-40
5/64"		30-60
3/32"		50-80
1/8"		70-110
5/32"		100-140

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