

# ES 310-16

SMAW

**ESWECO**  
*The Art of Welding*

Type Basic-rutile

E310-16

## Description

ES 310-16 is an austenitic, stainless-steel electrode for welding 25Cr20Ni steels. The weld metal resists scaling up to 1100-1150°C and does not contain any measureable ferrite. ES 310-16 can also be used for welding certain air-hardening steels such as armour plate and for welding stainless to unalloyed steel.

### Current

DC+, AC OCV 65 V



## Classifications

EN 1600	E 25 20 R 1 2
SFA/AWS A5.4	E310-16
Werkstoff Nr.	1.4842

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Cu
0.12	0.5	2.0	26.0	21.0	<0.2

## Typical mech. Properties all weld metal

Yield stress, MPa	560
Tensile strength, MPa	600
Elongation A4, %	35

### Charpy V

Test temps, °C	Impact values, J
+20	60

Ferrite content	FN 0
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## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	60-85	21
3.2	350	80-120	24
4.0	350	105-160	28