

ES 310-15

Type Lime-basic

SMAW

E310-15

ESWECO
The Art of Welding

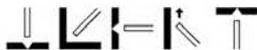
Description

ES 310-15 is a stainless-steel electrode for welding 25Cr20Ni steels. It is also suitable for welding armour steel, austenitic-manganese steel and for joining dissimilar steels. ES 310-15 deposits a very crack-resistant weld metal.

ES 310-15 used for cladding side of stainless clad steels and dissimilar steels, hydrogenation and polymerization plant, gas turbine combustion chamber parts, annealing boxes, high temperature furnace parts up to 1200 °C.

Current

DC+



Classifications

EN 1600	E 25 20 B 2 2
SFA/AWS A5.4	E310-15
Werkstoff Nr.	1.4842

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.12	0.5	2.2	26.0	21.0	<0.5	<0.5

Typical mech. Properties all weld metal

Yield stress, MPa	410
Tensile strength, MPa	590
Elongation A5, %	35

Charpy V

Test temps, °C	Impact values, J
+20	100

Ferrite content	FN 0
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Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	55-85	25
3.2	350	75-110	25
4.0	350	110-155	26