CEWELD®

310 Mo

CATEGORIE	SMAW beklede elektroden
TYPE	Heat resistant (modified) stainless steel alloy for SMAW
APPLICATIONS	Ceweld 310Mo electrodes are primarily intended for welding the clad side of 316, 316L and 317 clad steels as well as other grades of molybdenum bearing stainless steels. Ceweld 310Mo electrodes are used for the resurfacing of digesters in the paper industry
PROPERTIES	Ceweld 310Mo is a rutile basic electrode similar to Ceweld 4842 Ti but with molybdenum added for improved high temperature creep properties. The weld deposit is fully austenitic and corrosion resistant.
CLASSIFICATION	AWS A 5.4: E 310 Mo-16 EN ISO 3581-A: E 25 20 3 R 12 DIN: W.Nr. 1.4466 DIN 8556: E 25 22 2 NLB
SUITABLE FOR	1.4832, 1.4837, 1.4841, 1.4845, 1.4846, 1.4849, 1.4848, 1.4828, 1.4713, 1.4726, 1.4710, 1.4745, 1.4823 heat resisting stainless steel.
APPROVALS	CE approved
WELDING POSITIONS:	

WELD DEPOSIT ANALYSIS

C	Mn	Si	Cr	Ni	Mo
<0.10	1,5-2.0	0.5	22-24	19-21	2-3

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V +20°C	-40°C	-60°C	Hardness HV 40
AW	380	540	35	70			210

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+	kg / can	kg / 6pack	kg / 1000
2,5	300	60-90			19
3.2	350	75-120			35.8
4.0	350	100-155			54.5
5.0	350	130-210			84.7

REDRYING TEMPERATURE	300ºC/2hr (not often required)