310 Mo

WELDING ROD WITH A HIGH CHROMIUM AND NICKEL CONTENT TO WELD AND TO CLAD CARBON STEEL AND STEEL TYPES 25/20 Mo, 316,316L,317,309Cb,309Mo AND 347..

CLASSIFICATION A.W.S: E-310 Mo-16

APPLICATIONS: To build and repair parts in the chemical industry, in the paper industry, in oil refineries and in the petrochemical industry. It is recommended in the production and repair of machines and equipment submitted to severely corroding and high temperature conditions such as boilers, turbines, heat exchangers, condensers, crucibles, etc. It is recommended specially for those cases where it is not feasible to apply postweld heat treatment and in equipment to be used in industry and to be submitted to severe cleaning procedures-- continuous flow, rain, chemical treatment, brine and its fumes-- that ususally lead to pittings.

CHARACTERISTICS AND PROCEDURE: Filler metal deposits are highly resistant to corrosion and are free of carbide precipitation.Clean the joint area to remove dirt, scales, grease and rust. Use reverse polarity. Keep the arc short and do not let the welding rod contact the surface. Tilt the electrode slightly in the same direction as the weld. When welding high alloy steel with a low carbon content, special precautions have to be taken to avert cracks. This welding rod can be used in any welding position. Preheating up to 100 °C is recommended..

TENSILE RESISTANCE:	6,327 KG./CM2 (90,000 PSI)
BRINELL HARDNESS:	205 (RC-16)
ELONGATION:	40%
FERRITE No.:	0
POSITIONS:	ALL
CURRENT:	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %						SIZES	AMPERAGE
C	**Mn**	**Si**	**Cr**	**Ni**	**Mo**	2.38 mm-3/32"	50-70
0.10	1.80	0.75	26.0	21.0	2.50	3.25 mm - 1/8"	80-100
						4.0 mm - 5/32"	110-130
						5.0 mm - 3/16"	140-170