

# SUPRANOX RS 310

## MMA Electrodes Stainless and Heat resistant steels

Rutile coated MMA electrode depositing fully austenitic weld metal suitable for the welding of AISI 310 and heat resistant alloys (up to 1150°C) containing 25% Cr and 20% Ni.

Excellent weldability with a spatter free arc, self-releasing slag combined with a very smooth bead appearance.

Efficiency 100%. Packed in Gaspack system.

### Classification

AWS	A5.4: E 310-16
EN	1600: E 25 20 R 22

### Approvals

### Grades

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.09	2.20	1	≤ 0.030	≤ 0.030	25	21	0.40	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 350	≥ 550	≥ 30	≥ 60	-

### Materials

AISI 310; 1.4845 (X8CrNi25-21); 1.4841 (X15CrNiSi25-21); 1.4828 (X15CrNiSi20-12)

### Storage and redrying

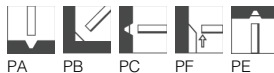
Keep dry and avoid condensation.

Re-drying not generally required

If necessary: 350-370 °C for 1 hour, 3 times max

### Current condition and welding position

AC; DC+



### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	45-70	18,3	10,9
3,2	350	70-120	34,5	20,7
4,0	350	110-140	53,5	32,1