

NC-310

For welding of 25%Cr-20%Ni stainless steel

AWS A5.4 E310-16
KS D 7014 E310-16
JIS Z3221 ES310-16

Applications

Welding of AISI (SUS) 310S.

Characteristics

NC-310 is a lime-titania type electrode for all-position welding, depositing weld metal of perfect austenitic structure.

The weld metal has good mechanical properties, especially high toughness in all welding condition as well as good corrosion resistibility and good heat resistibility.

Notes on usage

- (1) Keep the arc as short as possible.
- (2) Weaving width should be within two and a half times of the electrode's diameter.
- (3) When the electrodes have absorbed moisture, dry them at 150~200°C for 30~60 minutes before use.
- (4) As the weld metal becomes perfect austenitic structure because of much inclusion of alloy elements, beware of cracking.
- (5) Usually, preheat is not necessary.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Cr	Ni
0.10	1.58	0.35	0.021	0.008	26.11	20.85

Typical mechanical properties of weld metal

TS N/mm ² (kgf/mm ²)	EL %
600(61)	40

Typical corrosion resistance of weld metal

40% HNO ₃ (Nitric acid) Boiling	0.08g/m ² · hr
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Size & recommended current range (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	
	L (mm)	300	350	350	350
Amp.	F	40-80	70-110	110-140	140-170
	V&OH	35-75	65-100	105-135	-

• Approval : ABS

• Tip Color : Pink