

# Stainless Steel SMAW Electrodes

## G310

AWS A5.4 E310-16  
JIS Z 3221 ES310-16  
ISO 3581-A-E 25 20 R 1 2

### Product Features:

- Lime titanium oxide type stainless steel covered electrode.
- All deposited full austenite structure weld metal contains approximately 25%Cr, 20%Ni elements to get good corrosion/heat resistance, better toughness than high hardening tendency 13%Cr steel.

### Applications:

- Welding of SUS310 stainless steel.
- Welding of Cr-Mo steel.
- Welding of 13%Cr steel.

Typical chemical composition of all weld metal (wt%)

| C    | Si   | Mn   | Ni   | Cr   | Mo   | Fe   |
|------|------|------|------|------|------|------|
| 0.11 | 0.38 | 1.75 | 21.3 | 26.9 | 0.08 | Bal. |

Typical mechanical properties of all weld metal

| Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>% |
|-------------------------------------|---------------------------------------|-----------------|
| 427                                 | 582                                   | 34              |

Size (mm) & recommended welding parameters (A) AC or DC+

| Diameter / Length            | 2.6/300 | 3.2/350 | 4.0/350 | 5.0/350 |
|------------------------------|---------|---------|---------|---------|
| Flat position                | 60~85   | 85~120  | 115~150 | 150~200 |
| Vertical / overhead position | 50~75   | 75~105  | 95~130  | ----    |

### Note:

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