

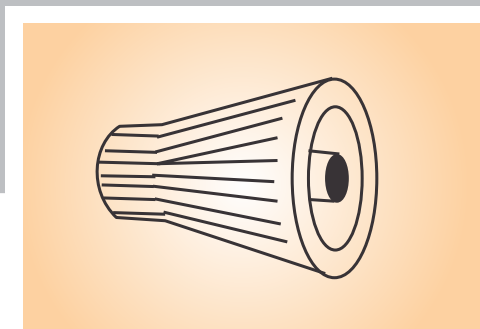
ESSEN[®] 31R

AC/ DC +

Stainless Steel electrodes For effective surface treatment

AWS A5.492 E310-16

For Heat & Oxidation Resistance with Excellent Corrosion Resistance Properties.



PROPERTIES

For welding AISI 310 heat resisting stainless steel. Ferritic and martensitic straight chromium steels can be welded where conditions allow. Mild steel to stainless steel can be welded. Resists high temperature oxidation.

MECHANICAL PROPERTIES

Tensile Strength (Mpa) = > 580 (= 58 Kg/mm²) Elongation (%) - > 37

APPLICATIONS

Welding of 25/20 stainless steel, also welding of any stainless steel to unknown steel. Applicable in high temperature application. Excellent strength and good weldability. Low spatter loss with high strength and elongation properties. Most suitable for vats, retorts, valves, tanks, heat exchangers, heat treatment trays and boxes, furnace parts etc.

WELDING PROCEDURE.

RECOMMENDED AMPERAGE	
Size	Current
2.50 mm x 350 mm	070 - 090 Amps
3.15 mm x 350 mm	090 - 110 Amps
4.00 mm x 350 mm	120 - 140 Amps

PACKING	
2.50mm x 350mm 2 Kg	42 pcs/kg (Approx.)
3.15 mm x 350 mm 2 kg	31 pcs/kg (Approx.)
4.00 mm x 350 mm 2 kg	19pcs/kg (Approx.)



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

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