

TECH-ROD 310

- I. **DESCRIPTION:** Tech-Rod 310 electrodes are used to weld stainless steels of similar composition in wrought and cast form. The weld deposit is fully austenitic, and as such calls for minimum heat input during welding.
- II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.4 Class E310-16.

III. **CHEMICAL COMPOSITION**

Carbon	.11
Manganese	1.90
Silicon	.52
Chromium	26.2
Nickel	20.95
Sulfur	.012
Phosphorus	.016
Iron	Balance

MECHANICAL PROPERTIES

Tensile Strength	
90,500 PSI	625 MPA
Yield Strength	
61,500 PSI	425 MPA
Elongation	34%

IV. **WELDING PARAMETERS**

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. **PACKAGES AVAILABLE:**

3/16"-10# can, 5/32"-10# can, 1/8"-10# Can, 3/32"-8# can