

Classification	
<b>AWS A5.4</b>	<b>EN ISO 3581-A</b>
E310-17	E 25 20 R

### Characteristics and typical fields of application

Avesta 310-17 is a 25 Cr 20 Ni electrode for welding to ASTM 310S and related types of high temperature stainless steels. 310 have a fully austenitic structure, which makes it somewhat more sensitive to hot cracking than 309L. Welding should be performed taking great care about low heat input and interpass temperature.

### Base Materials

Outokumpu 4845, EN 1.4845, ASTM S310S, BS 310S16, NF Z8 CN 25-20, SS 2361, EN 1.4841,

### Typical analysis of all weld metal (wt.-%)

C	Si	Mn	Cr	Ni
0.11	0.7	2.15	26.5	21.7

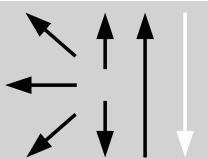
Ferrite Number  $\approx 0$

### Mechanical properties of all-weld metal

Heat treatment	Yield strength $R_e$ N/mm <sup>2</sup>	Tensile strength $R_m$ N/mm <sup>2</sup>	Elongation ( $L_0=5d_0$ )	Impact work ISO-V KV J	
	MPa	MPa	%	+ 20 °C	-20°C
Min. AWS A5.4	-	550	30	-	-
As Welded	430	620	35	80	60

Hardness Approx. 190 Brinell

### Operating data

	<b>Polarity</b> DCEP / AC	Heat Input: Max. 1.0 kJ/mm
		Interpass temperature: Max. 100°C
		Scaling Temperature : Approx. 1150°C
		Instruction for Re-drying: Re-dry for 3 h at 250-280°C before using

### Approvals

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### Size, Packaging and Electrical Operating Data

Size mm	Kg / Pack	Kg / Box	Amperage (A)
2.50 x 350	5.0	15.0	50-75
3.25 x 350	5.0	15.0	70-100
4.00 x 350	5.0	15.0	100-150