



# Selectarc Inox 310H

High Temperature  
Stainless Steel Electrode

## Classification

AWS A5.4 : E310H-15  
ISO 3581-A : E 25 20 H B 4 2

EN 1600 : E 25 20 H B 4 2

## Description & Applications

Basic coated austenitic stainless steel electrode with 26%Cr, 21%Ni and an increased carbon content. Used to weld austenitic heat resistant alloys, centrifugally cast tubes etc. resisting to scaling and oxidation up to 1100°C. Regular and stable fusion, good slag removal, nice aspect of the bead.

**Main applications:** Petrochemical industry, for furnaces, reformer and steam cracker tubes, piping systems.

## Base materials

UNS	Alloy	EN	Material N°
J93503		G-X40CrNiSi25-12	1.4837
J94204	HK 40	G-X40CrNiSi25-20	1.4848

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Fe
0.4	0.7	2.0	26.0	21.0	0.2	Rem.

## All Weld Metal Mechanical Properties

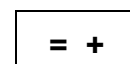
R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
>450	>650	>15

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x300	3,2x350	4,0x350
Current	( A )	70	100	135

Redrying 2 hours at 250°C, if necessary. Interpass temperature : < 150°C.

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