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| Technical data sheet <small>100122MBA</small> | Coated SMAW Electrode WA TETRA B 310-E |  Welding Alloys |
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CLASSIFICATION

| | |
|-------------------------------|------------------------------|
| ASME IIC SFA 5.4 / AWS A 5.4: | E310-15 |
| EN ISO 3581-A: | E 25 20 B 42 |
| ASME IX Qualification | QW432 F-N° 5 QW442 A-N° 9 |

DESCRIPTION AND APPLICATIONS

- Basic coated stainless steel SMAW electrode
- 25%Cr-20%Ni type
- Heat and scale resistant up to 1100°C.
- Highly resistant to hot cracking

DESCRIPTION AND APPLICATIONS

WA TETRA B 310-E is suitable for welding stainless steels of similar composition, especially in those applications where rutile welding consumables are unsuitable due to cracking.

Joining of heat resistant ferritic alloys.

Construction of combustion chambers, ovens, thermal equipment for heat treatment, petrochemical installation.

Examples:

| AISI | UNS | Material number | EN Symbol |
|------|--------|-----------------|------------------|
| 310 | S31000 | 1.4841 | X15 CrNiSi 25-21 |
| 310S | S31008 | 1.4845 | X12 CrNi 25-21 |

TYPICAL ALL-WELD METAL ANALYSIS [%]

| C | Si | Mn | Cr | Ni | Fe |
|-----|-----|-----|------|------|------|
| 0.1 | 0.5 | 2.3 | 25.5 | 20.5 | Bal. |

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

| Rm [MPa] | Rp0.2% [MPa] | A ₅ [%] | CVN [J] |
|----------|--------------|--------------------|-----------|
| 550 | 380 | 25 | +20°C: 70 |

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

| Rm [MPa] | Rp0.2% [MPa] | A ₅ [%] | CVN [J] |
|----------|--------------|--------------------|------------|
| 600 | 430 | 35 | +20°C: 100 |

OPERATING CONDITIONS

| Electrode Ø x L [mm] | 2.5 x 300 | 3.2 x 350 | 4.0 x 350 |
|----------------------|-----------|-----------|-----------|
| Current [A] | 70 | 100 | 135 |
| = + | | | |

Re-drying: 2h at 250°C, if necessary.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE

ASME IX: 1G, 2F, 2G, 3G, 4G

PACKAGING

| Electrode Ø x L [mm] | 2.5x300 | 3.2x350 | 4.0x350 |
|----------------------|---------|---------|---------|
| Weight/box [kg] | 4.0 | 5.0 | 5.0 |

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.