


<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Coated SMAW Electrode</b>  <b>WA TETRA V 310-E</b>	 <b>Welding Alloys</b>
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### CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4: (E310-16) nearest  
EN ISO 3581-A: E 25 20 R 32

### DESCRIPTION

- Rutile coated stainless steel SMAW electrode
- 25% chromium - 20% nickel deposit
- Excellent weldability in all positions, except vertical down
- Good resistance against hot cracks
- Complements Welding Alloys cored wires TETRA V 310-G and TETRA S B310-G

### APPLICATIONS

WA TETRA V 310-E is resistant to oxidation and scaling up to 1100°C. It is suitable for welding cast or wrought stainless steels of similar composition and for assembling heat resistant ferritic stainless steels.

#### 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	Mn	Si	Cr	Ni
0.1	2.0	0.9	25.5	20.5

Typical ferrite number: 0 FN

### MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
550	400	30	+20°C: 47

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
600	420	32	+20°C: 65

### OPERATING CONDITIONS

Electrode ØxL [mm]	2.0 x 300	2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 450
Current [A]	40 - 60	50 - 75	70 - 110	100 - 145	120 - 190
= +	~ 70V				

Re-drying: 2h at 250°C, if necessary.

### WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PD, PE, PF  
ASME IX: 1F, 1G, 2F, 2G, 3F, 3G, 4F, 4G

### PACKAGING

Electrode ØxL [mm]	2.0 x 300	2.5 x 300	3.2 x 350	4.0 x 350	5 x 450
Weight/box [kg]	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.