

AFROX 310



Afrox 310 is an all-position rutile basic coated electrode of the 25% chromium and 20% nickel type. It is suitable for welding AISI 310 grade materials and resists scaling in oxidising atmospheres at temperatures up to 1100°C while maintaining adequate joint strength.

CLASSIFICATIONS

AWS	A5.4	E310-16
SABS	1293	E25.20 R 26
BS EN	1600	E 25 20 R

APPROVALS

South African Bureau of Standards (SABS 1293 and ISO 9001).

CHEMICAL ANALYSIS

% Carbon	0.08 - 0.15	% Nickel	20.0 - 22.5
% Manganese	1,5 - 2,5	% Molybdenum	0.20 max
% Silicon	0.75 max	% Sulphur	0.025 max
% Chromium	25.0 - 28.0	% Phosphorous	0.025 max

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE AS WELDED
CONDITION)**

0,2% Proof Stress	370 MPa min
Tensile Strength	550 - 650 MPa
% Elongation on 4d	30 min
Charpy V-Notch at 20°C	65J min
Charpy V-Notch at -70°C	45J min
Charpy V-Notch at -196°C	35J min

PACKING DATA

(DC + AC 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current Amps	Item Number Multi-Kg pack	Pack Mass (Kg)
2.5	300	50 - 70	075-732	3 x 4
3.25	350	70 - 95	075-733	3 x 4
4	350	95 - 130	075-734	3 x 4

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