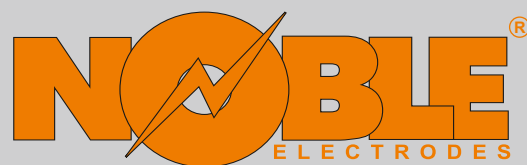


# NOBLE - 310

Stainless Steel Electrodes



## CLASSIFICATION

AWS - A5.4: E310-16

**Characteristics :** **NOBLE - 310** is a heavy coated, Rutile type electrode made from 25%Cr-20%Ni core wire to give 25-20 weld deposit which has excellent stability and oxidation resistance up to 1050°C. It gives smooth arc and uniform bead, low spatter loss and good slag removal properties.

**Applications :** **NOBLE - 310** is suitable for the welding of stainless steel types 310. It has application as cladding of stainless clad steels, straight chrome steels and dissimilar steels in hydrogenation and polymerization plant, gas turbine combustion chamber parts, high temperature furnace parts, annealing boxes and carbonizing pots.

## Mechanical Properties

Mechanical Tests	AWS Specifications
Tensile Strength	550 N/mm <sup>2</sup> (Min.)
Elongation	30 % (Min.)

\* If Moist: Re-dry at 250°C For 1 Hr.

## Weld Metal Chemistry (%)

Elements	C	Mn	Si	P	S	Ni	Cr	Mo
Range	0.20 Max	2.5 Max	0.75 Max	0.03 Max	0.03 Max	18 - 22	24 - 28	0.5 Max

## Packing Specifications & Current Condition :

Size (mm)	Pkts. / Case	Wt. / Pkt	Current (Amp.) AC (70V) DC (+)
2.50 x 350	05	2 Kg.	65 - 90
3.15 x 350	05	2 Kg.	80 - 100
4.00 x 350	05	2 Kg.	100 - 135

*“Noble – Characterized by all Excellent Qualities”*