

Standards:

EN ISO 3581-A: E 25 20 H R 12
 EN 1600: E 25 20 H R 12
 AWS A 5.4: E 310H -16
 Mat.-No.: ~1.4846

capilla® 310 H**Product description:**

Basic coated stick electrode for welding of heat resistant CrNi-steels. The weld metal is fully austenitic. It is resistant to low-sulphur, nitrogenous gases at service temperatures up to 1200°C.

Not resistant to high sulphuric gases.

Applications:

Suitable for welding steel grades like:

1.4826, 1.4837, 1.4848.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mn	Fe
Min.		23	19	2,5	
Max.	0,4	26	21	3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	600	[MPa]
Yield strength R _{p0,2} :	400	[MPa]
Yield strength R _{p1,0} :	450	[MPa]
Elongation (L=5d):	10	[%]

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,0	250/300	60 – 90
2,5	300	80 – 110
3,25	350	100 – 150
4,0	350	150 – 190
5,0	350	160 – 210

Polarity
= (+) ~

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 Capilla 310 KB

Capilla 310 H MAG
 Capilla 310 H WIG