Standards:

EN ISO 3581-A:	E 25 20 R 12
EN 1600:	E 25 20 R 12
AWS A 5.4:	E 310-16
Mat.-No.:	~ 1.4842

capilla® 310

Product description:

Rutile-basic coated electrode for welding of heat resistant austenitic steels;

The weld metal is fully austenitic and scaling resistant up to 1200°C. Deposited material is not resistant to sulphurous gases.

Applications:

Suitable for materials as:

1.4832, 1.4837, 1.4840, 1.4841, 1.4845, 1.4846, 1.4849, 1.4848, 1.4828, 1.4713, 1.4726, 1.4710, 1.4745, 1.4823

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mn	Fe
Min.		**23**	**19**	**2,5**	
Max.	**0,1**	**26**	**21**	**3**	**Bal.**

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m:	570	[MPa]
Yield strength $R_{p0,2}$:	380	[MPa]
Yield strength $R_{p1,0}$:	410	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	40	[J]

Positions: all except PG

Redrying: 300°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 =(+)~

also available:
find in table of content

Capilla 310 KB
Capilla 310 MAG
Capilla 310 WIG