Avesta 310 — Stick electrode

Classifications		high-alloyed
EN ISO 3581-A:	AWS A5.4:	
E 25 20 R	E310-17	

Characteristics and field of use

Avesta 310 is a 25 Cr 20 Ni electrode for welding 1.4845/ASTM 310S and similar types of high temperature stainless steels. To minimise the risk of hot cracking when welding fully austenitic steels and nickel base alloys, heat input and interpass temperature must be low and there must be as little dilution as possible from the parent metal.

Base materials

For welding steels such as					
Outokumpu	EN	ASTM	BS	NF	SS
4845	1.4845	310S	310S16	Z8 CN 25-20	2361

Typical analysis of all-weld metal (Wt-%)

C	Si	Mn	Cr	Ni
0.10	0.5	2.1	26.0	21.0

Mechanical properties of all-weld metal

Heat Treatment	*Yield strength 0.2%*	*Tensile strength*	*Elongation (L_0=5d_0)*	*Impact values in J CVN*	
	MPa	*MPa*	*%*	*+20°C:*	*-196°C:*
untreated	440	625	35	80	50

Operating data

Polarity = + / ~

Dimensions (mm)	*Amperage A*
2.5	50-75
3.25	70-100
4.0	100-150