



Stainless Steel Electrodes

ALPHA 310

Characteristics:

ALPHA 310 is a heavy coated, rutile based electrode for welding of 25/20 Cr/Ni stainless steels. The electrode is designed for high temperature applications where greater stability, corrosion resistance and oxidation resistance are required. The weld deposit can stand up-to 1150°C in continuous service. The electrode gives smooth arc, least spatter, easily removable slag and radiographic quality welds.

Applications:

For welding AISI 309, 310, Cladding side of stainless clad steels, Straight chrome steels, Gas turbine combustion chamber parts, High temperature furnace parts, Hydrogenation plants. For joining dissimilar steels, Mild Steel to Stainless Steel, Harden able steels such as Automobile springs, broken dies and tools etc.

Weld metal Composition

Element	Percent
C	0.10 Max
Si	0.90 Max
Mn	1.0-2.0
Cr	25-28
Ni	20-22

Classifications:

AWS A5.4	E-310-16
DIN 8556	E 25 20 R 26

Current Range & Packing Data:

Size MM DxL	Current Range (Amps) AC or DC (+)	Pieces per Packet	Pieces per Carton
2.00x300	40-50	150	900
2.50x350	50-75	100	600
3.15x350	90-110	60	360
4.00x350	110-140	40	240
5.00x350	140-170	30	180

Instructions:

- Keep electrodes dry.
- Do not use excessive current.
- Hold short arc.
- Use good fit-up on joints.
- Adopt proper sequence.
- Remove the slag with a stainless steel wire brush.

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