INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 310-16
DIN 8556: E 25.20 R 26
NFA 81-343: EZ 25.20 R 26

EN 1600: E 25.20 R 32
ISO 3581: E 25.20 R 26

FEATURES & APPLICATIONS

Ideal for joining unknown grades of stainless especially in high temperature applications
Smooth running electrode for joining type 310 stainless and
especially for dissimilar combinations of steels
• High alloy content allows use in high temperature applications for scale resistance.
• Extra low spatter emission minimizes clean-up.
• Weld metal is non-magnetic.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Fully austenitic with a ferrite number of 0.

Flux Color: Maroon

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>S</th>
<th>P</th>
<th>Cr</th>
<th>Ni</th>
<th>Mo</th>
<th>Cu</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>.09</td>
<td>2.2</td>
<td>.4</td>
<td>.008</td>
<td>.018</td>
<td>26</td>
<td>21</td>
<td>.2</td>
<td>.1</td>
<td>bal</td>
</tr>
</tbody>
</table>

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

TDS 1152 – Revision 01/10/14
Tensile Strength 84,000 PSI (580 MPa)
Yield Strength 59,000 PSI (410 MPa)
Elongation 37%
Impact Energy 100J: 68oF (20°C),
60J: -320oF (-196°C)
Hardness Brinell 200, Rockwell B88

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>1/16 (1.6)</th>
<th>5/64 (2.0)</th>
<th>3/32 (2.5)</th>
<th>1/8 (3.25)</th>
<th>5/32 (4.0)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum Amperage</td>
<td>25</td>
<td>30</td>
<td>55</td>
<td>75</td>
<td>90</td>
</tr>
<tr>
<td>Maximum Amperage</td>
<td>35</td>
<td>50</td>
<td>75</td>
<td>110</td>
<td>140</td>
</tr>
</tbody>
</table>

Welding Techniques: Material to be welded should be clean of all contaminants. Maintain a short arc and use stringer beads rather than a weave technique.

Welding Positions: Flat, Horizontal, Vertical up, Overhead

Deposition Rates:

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Length (mm)</th>
<th>Weldmetal/ Electrode</th>
<th>Electrodes per lb (kg) of Weldmetal</th>
<th>Arc Time of Deposition min/ lb (kg)</th>
<th>Amperage Settings</th>
<th>Recovery Rate</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/16 (1.6)</td>
<td>10&quot; (250)</td>
<td>.13oz (3.6g)</td>
<td>125 (275)</td>
<td>55 (121)</td>
<td>30</td>
<td>100%</td>
</tr>
<tr>
<td>5/64 (2.0)</td>
<td>12&quot; (300)</td>
<td>.14oz (4g)</td>
<td>114 (251)</td>
<td>47 (103)</td>
<td>40</td>
<td>100%</td>
</tr>
<tr>
<td>3/32 (2.5)</td>
<td>12&quot; (300)</td>
<td>.3 oz. (9g)</td>
<td>50 (109)</td>
<td>35 (76)</td>
<td>65</td>
<td>100%</td>
</tr>
<tr>
<td>1/8 (3.25)</td>
<td>14&quot;(350)</td>
<td>.7oz (20g)</td>
<td>22 (49)</td>
<td>21 (46)</td>
<td>95</td>
<td>100%</td>
</tr>
<tr>
<td>5/32 (4.0)</td>
<td>14&quot; (350)</td>
<td>1 oz (29g)</td>
<td>15 (33)</td>
<td>18 (40)</td>
<td>120</td>
<td>100%</td>
</tr>
</tbody>
</table>

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## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>1/16 (1.6)</th>
<th>5/64 (2.0)</th>
<th>3/32 (2.5)</th>
<th>1/8 (3.25)</th>
<th>5/32 (4.0)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Length (mm)</td>
<td>10&quot; (250)</td>
<td>12&quot; (300)</td>
<td>12&quot; (300)</td>
<td>14&quot; (350)</td>
<td>14&quot; (350)</td>
</tr>
<tr>
<td>Electrodes / lb</td>
<td>67</td>
<td>42</td>
<td>28</td>
<td>13</td>
<td>9</td>
</tr>
<tr>
<td>Electrodes / kg</td>
<td>147</td>
<td>92</td>
<td>62</td>
<td>29</td>
<td>20</td>
</tr>
</tbody>
</table>