



M-90 E310

FEATURES

- *GOOD HEAT RESISTANCE
- *GOOD MECHANICAL PROPERTIES
- *MARTENSITE STRUCTURE (ALL-WELD METAL)
- EASY TO REMOVE SLAG

APPLICATION

- *Basic rutile coated, fully austenitic all position electrodes.
- *Suitable for welding heat resistant Cr and Cr-Ni steels.
- *Oxidation and scaling resistance up to 1200°C

CLASSIFICATION

*A5.4/ ASME SFA5.4 E310.16

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0..10	0.6	1.9	0.018	0.013	26.5	20.6	

MECHANICAL PROPERTIES

T.S	EL
N/mm2 (lbs/in 2)	(%)
610 (88,400)	35

WELDING PARAMETERS

DIAMETER (mm)	2.5	3.2
LENGTH (mm)	350	350
CURRENT (amps)	50-85	70-100

CURRENT

*AC or DC +/-

WELDING POSITIONS


ASME:
ISO 6947



1G
PA



2G
PB



2G
PC



3G
PF



3G
PG



4G
PE



5G
PF/PG

Current

= + ~ (U₀: 70v)