



CEWELD E 310Mo

TYPE	Heat resistant (modified) stainless steel alloy for SMAW(Type 25 22 2L)					
APPLICATIONS	CEWELD E 310Mo electrodes are primarily intended for welding the clad side of 316, 316L and 317 clad steels as well as other grades of molybdenum bearing stainless steels. Ceweld E 310Mo electrodes are used for the resurfacing of digesters in the paper industry					
PROPERTIES	CEWELD E 310Mo is a rutile basic electrode similar to CEWELD 4842 Ti but with molybdenum added for improved high temperature creep properties. The weld deposit is fully austenitic and corrosion resistant.					
CLASSIFICATION	AWS	A 5.4: E 310Mo				
	EN ISO	3581-A: E 25 20 3 R 12				
	F-nr	4				
	FM	5				
	W.Nr.	1.4466				
SUITABLE FOR	ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21-30 1.4335 , 1.4435 1.4465 , 1.4466, 1.4577 X1CrNi25-21, X2CrNiMo18-14-3, X1CrNiMoN22-25-3, X1CrNiMoN25-22-2, X3CrNiMoTi25-25 UNS S31050, S31603 AISI 316L, 725LN, 310MoLN Sandvik 2RE69, Sandvik 3R60 U. Sandvik 3R60 G, Uranus 25 22 2, 2RE69, 3R60U.G (Sandvik),Cronifer 25.25.LCN					
APPROVALS	CE					
WELDING POSITIONS	     					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo
	0.1	0.5	1.7	23	20	2.2
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0.2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V RT	Hardness Vickers
	As Welded /	380	540	35		Avg. 210
REDRYING TEMPERATURE	300°C / 2 hr					
GAS ACCORDING EN 14175	None					