

CHS402

Pure Austenitic Stainless Steel Covered Welding Rod

AWS A5.4 E310-16
ISO 3581-A-E (25 20) R 3 2
ISO 3581-B-ES310-16
BS EN 1600-E 25 20 R 3 2
CSA W48 E310-16
JIS Z3221 D310-16
GB/T 983 E310-16

Type of Covering: Lime-titania

Welding Position: F, H, HF, OH, V

Type of Current: DCEP or AC

Features & Applications

Mainly be used for welding structures fabricated by similar composition heat-resisting stainless steels. Also it could be used for dissimilar steels welding and for welding chrome steels that hardenability is higher, such as Cr5Mo, Cr9Mo, Cr13 and Cr28 etc. The weld metal has excellent performance of oxidation-resisting between temperature 900 °C -1,100°C.

Chemical Composition of Deposited Metal (%)

	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
Standard	0.08-0.20	1.0-2.5	≤0.75	25.0-28.0	20.0-22.5	≤0.75	≤0.75	≤0.03	≤0.03
Typical	0.13	1.99	0.38	27.01	21.44	0.13	0.104	0.009	0.021

Mechanical Properties of Deposited Metal (AW)

	Tensile Strength Rm (MPa)	Elongation A4 (%)
Standard	≥550	≥30
Typical	655	39

Sizes Pieces & Recommended Current (DC⁺ or AC)

Size (mm)		2.0 x 250	2.5 x 250	3.2 x 300	4.0 x 350	5.0 x 350
Current (A)	F	25-50	50-80	80-110	110-160	160-200
	V, OH	25-40	40-65	70-95	95-140	—

- Notice:**
- 1) The rod should be baked at 250°C for 1 hour before use.
 - 2) The surfaces to be welded must be cleaned away impurities of oil contamination, rust, moisture and so on.
 - 3) DC⁺ is recommended since when AC the force of penetration is weaker. To avoid the core rod to be red current should be smaller.