



# CEWELD E 310Mo

**TYPE** Heat resistant (modified) stainless steel alloy for SMAW

**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

**PROPRIÉTÉS** 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
W.Nr.	1.4466
F-nr	4
FM	5

**CONVIENT POUR** **ISO 15608: 8.1 Austenitic  $\leq$  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

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Cr	Ni	Mo
0.1	0.5	1.7	23	20	2.2

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	380	540	35	210 HV

**ETUVAGE** 300°C / 2 hr

**GAS ACC. EN ISO 14175** None