

# S-310.15

TYPE : Basic(Lime)

AWS A5.4 / ASME SFA5.4 E310-15  
JIS Z3221 ES310-15  
EN 1600 - E 25 20 B

SMW

## Applications

Owing to the high content of alloying elements, durability is maintained in welding of carbon steel where deposited metal is diluted by the base metal. Suitable for welding of 13%Cr or clad part of 18%Cr-8%Ni stainless steel.

## Characteristics on Usage

- S-310.15 is a basic type, all-weld metal has fully austenite structure.
- All-weld metal has a good mechanical property, especially excellent toughness.

## Notes on Usage

- ① Keep the current as low as possible and the arc length as short as possible.
- ② Dry the electrodes at 350°C(662°F) for 60 minutes before use.

## Welding Position



1G 2F 3G 4G  
(PA) (PB) (PF) (PE)

## Current

DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni
0.09	0.41	2.31	0.019	0.004	25.6	20.6

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)
565 (82,100)	34.8

## Approval

## I Packing

Packet 2.5 kg (5.5 lbs)  
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F	25~55	50~85	70~115	95~150	135~180
V-up, OH	30~40	60~75	85~115	105~140	-