



# HILCO HILCHROME 310R

Stick electrodes – stainless steel – heat resistant

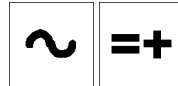
AWS A5.4: E310-16

EN ISO 3581-A: E 25 20 R 1 2

Werkstoffnr. 1.4842

**Coating type:**  
Rutile-basic

**Current:**



**Welding positions:**



Hilchrome 310R is our rutile-basic coated electrode for joining and surfacing 25Cr20Ni austenitic heat resistant Cr-, CrSi, CrNi and CrNiSi as well as ferritic-pearlitic CrAl steel grades. Maximum operating temperature in a non-sulphurous environment is 1150°C. When exposed to sulphurous gases (max. 2 g S/Nm<sup>3</sup>) we recommend a maximum working temperature up to 1040°C. Typical applications include annealing plants, hardening plants, steam boiler construction, crude oil industry and ceramic industry. Hilchrome 310R is core wire alloyed, AC/DC.

**Base materials to be welded:**

- ASTM/AISI Gr. 310 and similar heat resistant steels
- WNr. 1.4841, 1.4828, 1.4845, 1.4713, 1.4724, 1.4742, 1.4762
- Heat resisting rolled, forged and cast steels

**Applications:**

- Power Industry
- Repair & Maintenance

**Chemical composition, wt. % weld metal – typical:**

C	Mn	Si	Cr	Ni
0,12	2,0	0,5	26,0	21,0

**Mechanical properties, weld metal – typical:**

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 380	≥ 570	≥ 35	20°C ≥ 80

**Packaging and welding data:**

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	350	35,4	65-105
4,0	350	48,0	100-140