

EXCALIBUR® 310-16

Stainless • AWS E310-16



KEY FEATURES

- Used for high operating temperature stainless applications
- Multiple purpose austenitic, heat resistant stainless
- Minimal heat input required during welding
- Low silicon and high manganese levels are desired to prevent

CONFORMANCES

AWS A5.4/A5.4M: 2012	E310-16
ASME SFA A5.4:	E310-16

TYPICAL APPLICATIONS

- Heat Shields
- Furnace Parts
- Ducting
- Welding 310/310s materials

WELDING POSITIONS

All, except vertical down

DIAMETERS / PACKAGING

Diameter		Length		8 lb (3.6 kg) Easy Open Can	10 lb (4.5 kg) Easy Open Can
in	(mm)	in	(mm)	24 lb (10.9 kg) Master Carton	30 lb (13.6 kg) Master Carton
3/32	(2.4)	12	(305)	ED034993	
1/8	(3.2)	14	(355)		ED034994
5/32	(4.0)	14	(355)		ED034995

DEPOSIT COMPOSITION(1) - As Required per AWS A5.4/A5.4M: 2012

	%C	%Cr	%Ni	%Mo	%Mn	%Si
Requirements						
AWS E310-16	0.08 - 0.20	25.0 - 28.0	20.0 - 22.5	0.75 max	1.0 - 2.5	0.75 max
Typical Results(2)	0.11	25.5	21.0	0.1	2.0	0.58
	%P	%S	%CU	FN		
Requirements						
AWS E310-16	0.03 max	0.03 max	0.75 max	Not Required		
Typical Results(2)	0.02	0.01	0.02	-		

TYPICAL OPERATING PROCEDURES

Polarity(5)	Current (Amps)			
	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
AWS E310-16				
DC+/AC	40 - 80	75-110	95 - 150	130 - 200