

AI-0210

Specifications

AWS/ASME 11C SFA 5.4 : E 310-16

DIN 8586: E25-20 R23

Description and Applications

Rutile coated electrode for welding steels containing 20-27% Cr and 18-22% Ni when fine bead appearance and easy working conditions are required. Deposit has excellent high temperature properties.

Alloy can be used in air up to 1100°C, in oxidizing sulphurous atmospheres up to 1000°C and in reducing sulphurous atmospheres up to 600°C. It has a scaling temperature of approximately 1175°C.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe
0.10	1.35	0.70	26.5	21.0	Bal

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength:	590MPa
Yield Strength (0.2%):	420MPa
Elongation:	33% (4d)
Microstructure:	Austenite
Charpy:	175J

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	50-80
3.2	DC /AC	80-110
4.0	DC /AC	110-140

Also Available as solid Mig wire: See **AI-1710** and **TIG wire: AI-0210T**

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

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