



## **M-90 E310**

### **FEATURES**

- \*GOOD HEAT RESISTANCE
- \*GOOD MECHANICAL PROPERTIES
- \*MARTENSITE STRUCTURE (ALL-WELD METAL)
- EASY TO REMOVE SLAG

### **APPLICATION**

- \*Basic rutile coated, fully austenitic all position electrodes.
- \*Suitable for welding heat resistant Cr and Cr-Ni steels.
- \*Oxidation and scaling resistance up to 1200°C

### **CLASSIFICATION**

\*A5.4/ ASME SFA5.4 E310.16

### **CHEMICAL COMPOSITIONS**

C	Si	Mn	P	S	CR	Ni	MO
0..10	0.6	1.9	0.018	0.013	26.5	20.6	

### **MECHANICAL PROPERTIES**

T.S	EL
N/mm2 (lbs/in 2 )	(%)
610 (88,400)	35

### **WELDING PARAMETERS**

DIAMETER (mm)	2.5	3.2
LENGTH (mm)	350	350
CURRENT (amps)	50-85	70-100

### **CURRENT**

\*AC or DC +/-

# WELDING POSITIONS


ASME:  
ISO 6947



1G  
PA



2G  
PB



2G  
PC



3G  
PF



3G  
PG



4G  
PE



5G  
PF/PG

Current

= + ~ (U<sub>0</sub>: 70v)