



PHILARK PH 310

Coated Electrode for joining difficult to weld Steels exposed to high temperatures



General Description

The improved chromium-nickel-Moly electrode of stainless steel especially in high temperature applications. Smooth running electrode for joining type 310 stainless and especially for dissimilar combinations of steels.

High alloy content allows use in high temperature applications for scale resistance. Extra low spatter emission minimizes clean-up. Weld metal is non-magnetic and fully austenitic with ferrite number of 0.

This high-quality stainless-steel electrode has excellent scaling and oxidation resistance up to 1200°C.

Oxidation Resistance	■	■	■	■	■	■	■	■	■
Crack Resistance	■	■	■	■	■	■	■	■	■
Heat input	■	■	■	■	■	■	■	■	■

Mechanical Properties of Weld Metal

Tensile strength : 85,000 PSI

Hardness: 190-200 BHN

Elongation : 37%

Procedure:

Remove all fatigued material by gouging and subsequently grinding.

Keep the arc short for forming stringer beads. Avoid weaving.



Typical Applications

- Furnace Parts
- Joining dissimilar steels in high temperature exposed regions
- Heat Treatment pots and baskets
- Heat Exchangers
- Anchor Joints
- Valves

Boiler Baffles

Welding Parameters:

Current Type and Polarity : AC/DC(+)

Welding Positions: All Flat, Vertical, Overhead

Diameter [mm]	2.50	3.15	4.0
Length [mm]	350	350	350
Current [A]	50-75	90-120	115-140

