



PHILARK PH 310 HT

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



General Description

The improved chromium-nickel-Moly-Cobalt- electrode PHILARK 310 HT is designed to join dissimilar stainless steels and stainless steels to Carbon steels and stainless steels of unknown composition. The chemistry of it has been improved to work with AISI grade 310 and mild steels. The Typical Chemical Composition constitutes Cr-26%, Ni-22%, Co-2.8% and Mo -2.3%. This high-quality stainless-steel electrode has excellent scaling and oxidation resistance up to 1300°C.

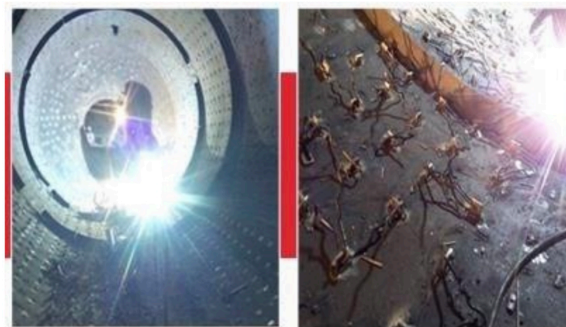
Oxidation Resistance	
Crack Resistance	
Heat input	

Mechanical Properties of Weld Metal

Tensile strength (at 500 degrees C): 95,000 PSI
Hardness: 190-200 BHN

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

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

PHILARK ALLOYS

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