

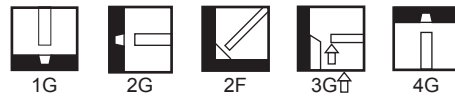
# PRIMALLOY™ JS-310



## CONFORMANCE:

- AWS A5.4/A5.4M: E310-16

## WELDING POSITIONS:



## APPLICATIONS:

- Designed for the welding on similar composition stainless steels
- Mainly application in petro-chemical machinery & pressure vessel industry

## REDRYING:

For electrodes that have had a short or mild exposure to the atmosphere, re-drying at 300°C for 1 hour will be sufficient. For electrodes that have been exposed to longer or more aggressive conditions or critical work environment, re-drying at 300-350°C for 1-2 hours is recommended. After re-drying, electrodes should be stored in a portable electrode drying oven.

## PRODUCT FEATURES:

- A Rutile-Basic high CrNi-alloyed all position electrode
- Weld on DCEP polarity with outstanding operation property
- High resistance to porosity & cracking
- High corrosion resistance at elevated temperature

# PRIMALLOY™ JS-310

## DIAMETERS / STANDARD PACKAGING

Dia. x Length (mm x mm)	Weight / Inner box (KG)	Weight / Outer carton (KG)
2.5 x 300	4	16
3.2 x 350	5	20
4.0 x 350	5	20
5.0 x 350	5	20

Please contact your local Lincoln Electric sales office for more alternative types of packaging.

## WELD DEPOSITE CHEMICAL COMPOSITIONS (Wt-%) -- TYPICAL

PRODUCTS		C	Si	Mn	P	S	Cr	Mo	Ni	Cu
PRIMALLOY™ JS-310	AWS requirements	0.08-0.20	≦ 0.75	1.0-2.5	≦ 0.030	≦ 0.030	25.0-28.0	≦ 0.75	20.0-22.5	≦ 0.75
	Typical value	0.086	0.36	2.30	0.017	0.006	25.70	0.10	21.05	0.005

## ALL WELD METAL MECHANICAL PROPERTIES -- TYPICAL

Lincoln Electrodes		Tensile Strength (MPa)	Elongation (%)
PRIMALLOY™ JS-310	AWS requirements	550	25
	Typical value	580	35

## RECOMMENDED WELDING PARAMETERS (CURRENT POLARITY: DC+)

Welding Position		2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 350
Current (A)	1G 2G 2F	50-85	80-120	100-150	140-180
	3G up, 4G	45-80	70-110	90-140	---

### Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

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### Authorized Distributor:

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