

**Standards**

TS EN ISO 3581-B	: ES 310 Mo-16
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AWS A5.4	: E 310 Mo-16

**Chemical Composition of  
Weld Metal % (Typical)**

C	Cr	Ni	Mo
0.08	25.0	21.0	2.8

**Mechanical Properties**

Tensile Strength (N/mm <sup>2</sup> )	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 550	min. 30

**Typical Base Material Grades**

- For austenitic steels, Cr-Mo Steels, coated stainless steels and type AISI 316, 316L and 317 clad steels.

**Features and Applications**

- Rutile-basic coated electrode
- The addition of Mo is improved high temperature creep properties
- The weld deposit is full austenitic and corrosion resistant

**Welding Positions**

**Current Type**

D.C.(+)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101178	3.20 x 350	1/8 x 14"	80 - 110	3510
3010101183	4.00 x 350	5/32 x 14"	110 - 140	5140

**Approvals:** SEPRO