

OK 310Mo-L

Basic electrode for joining and cladding of steel containing 25% Cr 22% Ni 2% Mo N type. The weld metal has an excellent resistance to very aggressive corrosive media, such as in urea plants. The fully austenitic weld metal is insensitive to hot cracking. OK 310Mo-L is approved for construction and repair of urea plants using the stamicarbon process. The electrode is regularly used for routine repair works on AISI 316L in urea plants to gain superior resistance to corrosive attack.

Specifications	
Classifications	EN ISO 3581-A : E 25 22 2 N L R 1 2 SFA/AWS A5.4 : (E310Mo-16)
Approvals	Snamprogetti : Ureaplants Stamicarbon : Ureaplants

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Ferrite Content	FN 0
Alloy Type	25Cr 22Ni 2Mo N
Coating Type	Rutile Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	442 MPa	623 MPa	34 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C	54 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.038	4.4	0.4	21.7	24.2	2.4	0.14	0

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	55-70 A	24 V	72 %	52 sec	0.9 kg/h
3.2 x 350.0 mm	70-100 A	24 V	56 %	62 sec	1.1 kg/h
4.0 x 350.0 mm	100-140 A	25 V	55 %	62 sec	1.7 kg/h