Intherma 310 (25.20 Super R)

TOP FEATURES

- Fully austenitic weld metal with high Cr and Ni content for very high service temperature
- High resistance against oxidation and scaling up to 1200°C
- Weldable on AC and DC

CLASSIFICATION

AWS A5.4	E310-16
EN ISO 3581-A	E 25 20 R 1 2

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Min.	0.08	2.0	not specified	not specified	not specified	25.0	20.0	not specified	not specified
Max.	0.15	5.0	0.70	0.025	0.030	27.0	22.0	0.50	0.50
Typical	0.12	3.5	0.4	0.008	0.02	26	21	0.2	0.1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded		Min.	Typical
Tensile strength	(MPa)	560	575
0.2% Proof strength	(MPa)	350	400
Elongation (%)		30	37
	5d	25	35
Reduction of area (%)		not specified	50
Impact ISO-V (J)	+ 20°C	not specified	80
	- 196°C	not specified	45
Hardness (HV)		not specified	200

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-90
3.2 x 350	75-120
4.0 x 350	100-155

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	100	2.1	INTH310-25-2
3.2 x 350	VPMD	60	2.0	INTH310-32-2
4.0 x 350	VPMD	40	2.0	INTH310-40-2

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.