



# LKE-310-16

LINKWELD ALLOYS INC.

AWS A5.4 E310-16  
 EN EN1600 E 25 20 R 1 2  
 JIS Z3221 D310-16

### Characteristics:

Heat resistance, corrosion resistance and toughness of LKE-310 are good. The weld metal is a full austenite structure containing 25%Cr-20%Ni. It is not necessary to preheat and postweld heat treatment.

### Applications:

It is suitable for the welding of dissimilar metals, low-temperature service stainless steel, mild steel and Cr-Mo steel.

### Notes on Usage:

1. Dry the electrodes at 200-250°C for 60 minutes before use.
2. Use lower currents for dissimilar metals welding. Keep the interpass temperature below 150°C
3. The weld metal is a full austenite structure, which is easy to cause hot cracking.

### Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni
0.080	1.90	0.40	0.010	0.010	27.30	21.00

### Typical mechanical properties of weld metal

TS N/mm <sup>2</sup>	EL %
590	38

### Welding position:



### Sizes and recommended current range (AC or DC <+> )

Diameter (mm)		2.0	2.6	3.2	4.0	5.0
Length (mm)		250	300	350	350	350
Amps	F	30-55	50-85	80-120	100-150	140-180
	V&OH	20-50	45-80	70-110	90-135	-
Weight per pack(kg)		4/5	4/5	5	5	5
Weight per carton (kg)		20	20	20	20	20