



# USA 310-16 Coated Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
825 Groves Street  
Lowell, NC 28098  
[www.weldingwire.com](http://www.weldingwire.com)

Quality Management System  
in accordance with  
**ISO 9001**  
Cert # 05-R0925



## ALLOY DESCRIPTION AND APPLICATION;

USA 310 is considered a general purpose electrode used mainly for welding AISI 310 stainless steel but also for straight chromium stainless as well as almost any analysis of carbon and alloy steel. The weld deposit of this electrode will have an austenitic structure with a chemical analysis and oxidation resistance similar to that of the base plate. 310 provides easy slag removability and a flat regular bead with fine appearance. More common applications include 25% Cr - 20% Ni stainless steel, Cr-Mo stainless steel to mild steel, and the clad side of 18% Cr - 8% Ni stainless clad steel. USA 310 can be used in all positions.

## TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps	Diameter	Amps
1/16"	15-40	1/8"	75-110
5/64"	30-50	5/32"	100-140
3/32"	50-75	3/16"	160-200

Arc Length = short arc, Flat use 15° angle from 90°, Vertical up & Overhead use weaving techniques within puddle

Procedures may vary with change in position, base metals, filler metals, equipment, and other changes.  
When welding vertical reduce amperage 10-20%

## TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	0.120	Phosphorus	0.020
Manganese	1.860	Sulfur	0.011
Silicon	0.400	Nickel	21.00
Chromium	26.500		

Elongation 35%  
Yield Strength (psi) 65,000  
Tensile Strength (psi) 90,000

Iron balance and all single values are maximum percentages

**AVAILABLE SIZES:** TF 310-16 = 3/32", 1/8", 5/32", 3/16"

**SPECIFICATIONS;** ANSI/AWS A5.4 E310-16  
ASME SFA 5.4 E310-16



2021 DC

EAST COAST	GULF COAST	WEST COAST	NORTHEAST COAST
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