

# SHUBER E 610

## STAINLESS STEEL - ALL PURPOSE



### DESCRIPTION

UNIVERSAL STAINLESS STEEL ELECTRODE FOR WELDING ALL KINDS OF STAINLESS STEEL AND HIGHLY SUITABLE FOR HIGH HEAT APPLICATIONS. Provides weld metal having a scaling temperature of 1200°C and superior strength at high temperatures. Primarily recommended for welding furnace parts, heat treating boxes, burners and cement kiln parts. Best for welding stainless steel to unalloyed steel and certain air hardening steels such as armour plate.

### SPECIAL FEATURES

- Superior corrosion resistance to organic & inorganic acids.
- Perfect for welding stainless steel of unknown composition.
- Excellent weldability in all positions.

### APPLICATION INSTRUCTIONS

Deposit stringer beads with as short an arc as possible. Avoid weaving to prevent slag inclusions. Use skip or stepback technique to avoid overheating and warpage. Remove slag between each pass.

### TYPICAL WELD METAL ANALYSIS:

C	Cr	Mn	Ni	Si
0.10	26.0	1.80	20.0	0.40

**TENSILE STRENGTH:** 67 kg/mm<sup>2</sup> (95,000 psi)

**ELONGATION:** 47%

### RECOMMENDED CURRENT:

AC or DC +(Reverse Polarity)

DIAMETER	AMPS
2.4 mm (3/32")	55 - 85
3.2 mm (1/8")	70 - 110
4.0 mm (5/32")	100 - 150

Tip Colour: Red

DIN 8556:  
E Ti 25 20 26