

Filler rod and wire

Features:	▪ Suitable for 25%Cr-20%Ni steel
Classification:	AWS A5.9 ER310
Shielding gas:	Ar
Identification color:	1st Gold
Polarity:	DCEN

Packaging data

φ mm	Spool	Tube		
	kg	kg	Length mm	g/piece
1.0	10	-	-	-
1.6	-	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
Volume mm	240W, 110H, 240L	40W, 35H, 1015L		

Composition (rod and wire mass%)

	Typical	Guaranty ^a
C	0.11	0.08~0.15
Si	0.49	0.30~0.65
Mn	1.8	1.0~2.5
P	0.01	0.03
S	<0.01	0.03
Ni	21.2	20.0~22.5
Cr	26.7	25.0~28.0
Mo	0.02	0.75
Cu	0.02	0.75

Note: ^aSingle values are maximum.

Welding parameters (A)

φ mm	
1.0	50~80
1.6	100~200
2.0	100~200
2.4	150~250

All-weld mechanical properties

	Typical
0.2%YS (MPa)	450
TS (MPa)	610
El on 4d (%)	39
IV 0°C (J)	110