

310 LMo Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Manganese alloyed chromium-nickel-molybdenum filler material

APPLICATIONS The weld deposit has excellent low temperature toughness that makes it suitable for joining stainless steels for cryogenic service

PROPERTIES 310 LMo has been developed primarily to cope with the severe corrosion conditions existing in the urea industry. Therefore, this filler has excellent resistance to corrosion in ammonium carbamate and nitric acid

CLASSIFICATION

AWS	A 5.9: ER 310LMo
EN ISO	14343-A: 25 22 2 N L
DIN: W.Nr.	1.4466

SUITABLE FOR Heat resistant stainless steels, UNS S31050, 1.4466, UNS S31603, 1.4435

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS

C	Si	Mn	P	S	Cr	Ni	Mo	N
		4.5			25	22	2.1	0.13

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HV
				+20°C	-40°C	-196°C	
AW	335	580	42	120		100	170

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters Current (A) DC-	Packing (kg)	
		single	master
1.6 x 1000	50-80	5	25
2.0 x 1000	70-110	5	25
2.4 x 1000	110-180	5	25
3.2 x 1000	150-250	5	25

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: I1