

310L

CATEGORY GMAW-GTAW Solid wires

TYPE High heat resistant stainless steel welding wire for Tig welding.

APPLICATIONS Common applications include heavily oxidizing media such as pipes in preheaters, coolers and condensers in the chemical industry.

PROPERTIES 310L has very good resistance to intergranular corrosion, pitting and stress corrosion cracking due to its high chromium and nickel contents.

CLASSIFICATION

AWS	A 5.9: ER 310L
EN ISO	14343-A: W 25 20 L
DIN: W.Nr.	1.4842

SUITABLE FOR Heat resistant stainless steels

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS

C	Si	Mn	P	S	Cr	Ni	Mo	Co	Cu
	0.2	1.6			24	20			

MECHANICAL PROPERTIES

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

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters	Packing (kg)	
		single	master
1.6 x 1000	Current (A) DC-	5	25
	50-80		
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