

TI 310

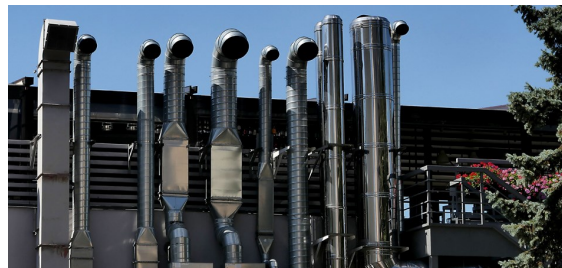
TIG Welding Wire - Stainless Steels

Standards	
AWS/ASME SFA - 5.9	ER310
EN ISO 14343 - A	W 25 20
TS EN ISO 14343 - A	W 25 20
DIN M. No.	1.4842

Materials		
Width	Material	ASTM
G-X15CrNi25-20	1.4840	
X15CrNiSi25-21	1.4841	314
	1.4842	310
X8CrNi25-21	1.4845	310S
X8CrNiTi18-10	1.4878	321H
GX25CrNiSi18-9	1.4825	

Properties and Applications

Fully austenitic welding rod for GTA (TIG) welding of heat resisting steels containing approximately 25% chromium and 20% nickel which are used in heat treatment and industrial furnaces and equipments, like cement and steel industries. Also suited for welding heat resisting and non-scaling ferritic chromium steels, provided that corrosion attack by reducing sulphur bearing combustion gases is not to be expected. Non-scaling up to 1200°C. Weld metal exhibits good toughness values down to -196°C.



Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni
Welding Wire	0.10	0.40	1.60	26.00	21.00

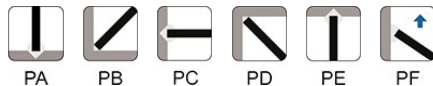
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	I1	450	580	36	20°C → 150	-60°C → 100

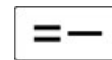
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
1.20x1000
1.60x1000
2.00x1000
2.40x1000
3.20x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23104EBKM2	1.20x1000	5 kg	5.30	4	21.40	Cardboard Tube
23104GBKM2	1.60x1000	5 kg	5.30	4	21.40	Cardboard Tube
23104HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
23104IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube

23104LBKM2	3.20x1000	5 kg	5.30	4	21.40	Cardboard Tube
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Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.