

# MI 310

Gazaltı (MIG/MAG) Kaynak Teli - Stainless Steels

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

Materials		
Width	Material	ASTM
GX40CrSi24	1.4745	
GX40CrNiSi27-4	1.4823	
GX25CrNiSi20-14	1.4832	
X12CrNi23-13	1.4833	309S
GX40CrNiSi25-12	1.4837	
G-X15 CrNi 25 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 stainless steel wire electrode for GMA (MIG/MAG) welding of heat resistant steels, containing approx. 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 resistant and scaling resistant ferritic chromium steels, provided that corrosion attack by reducing sulphur-bearing combustion gases is not be expected. Weld metal exhibits good toughness down to -196°C and non-scaling up to 1200°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 <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	M13	440	600	28	-20°C → 120

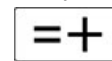
\* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M13 (Ar+%0,5-3 O2) .

## Application Information

### Welding Positions



### Polarity:



### Protection Gas:

M13 M12 M14 I1

### Welding Parameters & Efficiency

Diameter (mm)
0.80
1.00
1.20

## Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23004BJAM2	0.80	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23004DBAM2	1.00	5 kg	5.30	1	5.30	Plastic Spool (D200)

23004DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23004EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

**Storage & Re-Drying Information**

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