GM 310

IDENTIFICATION :ER 310

CLASSIFICATION :AWS A 5.9 ER310 BS2901-90 309S94 DIN 8556-86 ~SGX12CrNi 2520

CHARACTERISTICS :

GM 310 is a solid stainless wire which is primarily intended for welding the 25 % Cr / 20% Ni, type 310, fully austenitic stainless steel used for corrosion and oxidation resistance at elevated temperatures. Deposited weld metal is of radiographic quality.

APPLICATIONS :

For joining difficult to weld steels such as armour plate and ferrite stainless steels as well as dissimilar steels. Used for welding in furnace and heat treatment equipment. ASTM 310, 310S, CK 20 (Cast) DIN 1.4840(Cast), 1.4841, 1.4842, 1.4843, 1.4845

COMPOSITION OF THE WIRE (RANGE) %:

C	Mn	Si	Cr	Cu	Ni	Mo	S	P
0.08 - 0.15	1.0-2.50	0.30-0.65	25.0 - 28.0	0.50 max	20.0 - 22..5	0.50 max	0.025 max	0.030 max

MECHANICAL PROPERTIES (RANGE) :

Tensile Strength N/mm^2	Yield Stress N/mm^2	Elongation(%)(L=4D)	Charpy V-notch impact strength (joules)

550 - 650	370 - 470	30 - 38	Temp	Joules
			0°C	60- 100
			-196°C	50 - 80

SHIELDING GAS : Argon 99.99% 6-12 l/min

WELDING CURRENT : DC (-)

CORROSION RESISTANCE:

Ferrite content in the weld metal : O F N

Designed for high temperature oxidation applications. Its resistance to wet corrosion is limited.

PACKING DATA :

SIZE (mm)	LENGTH (mm)	PACKING/BOX
1.6	1000	5Kg
2.0	1000	5Kg
2.4 / 2.5	1000	5Kg
3.15/3.2	1000	5Kg
4.0	1000	5Kg