Cromamig 310

GMAW - MIG MAG

Stainless Steel

Date: 2008-01-22
Revision: 8

Description:
Cromamig 310 is primarily intended for welding the 25% Cr / 20% Ni, type 310, fully austenitic stainless steels, used for corrosion and oxidation resistance at elevated temperatures. Suitable also for joining difficult-to-weld steels such as armour plate and ferritic stainless steels as well as dissimilar steels.

Welding current:
DC+

Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min	0,08	0,30	1,0			24,0	18,0
Typical	0,11	0,40	1,6	0,02	0,01	25,5	20,5
Max	0,15	0,65	2,5	0,03	0,02	27,0	22,0

	Mo	Cu
Min		
Typical	0,10	0,10
Max	0,30	0,30

Shielding gas:
Acc. to EN 439:
M12, Ar + 2% CO2, 16-21 l/min
M13, Ar + 1-3% O2, 16-21 l/min

Corrosion resistance
Designed for high temperature oxidation applications and its resistance to wet corrosion is limited.

Scaling temperature:
1150°C in air. Reducing combustion gas, free of sulphur 1080°C, maximum 2g S/m3 1040°C.

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,11	0,4	1,5	0,02	0,01	25,0	20,0
Max							

	Mo
Min	
Typical	0,10
Max	

Mechanical properties

	Specified	Typical
Yield strength, Rp0.2%:	300 MPa	390 MPa
Tensile Strength, Rm:	550 MPa	590 MPa
Elongation, A5	30%	40%
Impact energy, CV:		20°C • 170 J
		-196°C • 60 J

Classification:

EN ISO 14343	G 25 20
AWS A5.9	ER310

Approvals:

Product data

Diam.mm	Product code	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
1,0	9806-2010	75-140	18-21	170-200	26-28
1,2	9806-2012	130-160	18-21	175-250	26-28