



AWS	A5.9 ER310
EN	EN12072 G 25 20
JIS	Z3321 Y310

Characteristics:

It is austenitic stainless steel filler metal with good general oxidation resistance at high temperature. It is excellent corrosion and heat resistance, ideal for welding and building up parts for heat treatment and case hardening furnaces and other burners.

Applications:

It is suitable for welding of 25%Cr-20%Ni stainless steel and dissimilar steels. Typical application include marine, re-conditioning and refurbishment industries.

Notes on Usage:

1. For TIG process, use DC(-) current, Argon Shield and Tungsten Electrode.
2. For MIG process, use Spray Transfer or Short Circuit Transfer mode.
3. 98%Argon – 2%O₂ shielding gas is recommended in MIG process.

Typical chemical composition of weld metal (wt%)

C	Cr	Ni	Mn	Si
0.12	27.00	21.50	1.36	0.49

Typical mechanical properties of weld metal

TS N/mm ²	EL %
610	41

Sizes available

MIG Solid Wire(mm)	0.8	0.9	1.0	1.2
TIG Rods(mm)	1.6	2.0	2.4	3.2