

## MIDALLOY MASTERCOR™ E310T0-1/4 FLUX CORED WIRE

### CLASSIFICATION

- AWS 5.22 Class E310T0-1/4 / ASME SFA A5.22 Class E310T0-1/4, UNS W31031, ASME Sec. IX, F6, A9

### DESCRIPTION

MIDALLOY MASTERCOR™ E310T0-1/4 is a flux-cored wire used to weld type 310 stainless steel. MASTERCOR E310T0-1/4 has excellent slag removal and runs with a spatter free globular transfer. The weld deposit has no ferrite and care must be taken to avoid hot cracks. This is accomplished by low heat input and making "convex" bead profiles.

### APPLICATIONS

This base material plate specification is listed under UNS N31000. There are many product forms that are covered under other ASTM and ASME SA specifications (i.e. SA240, 182, A276 etc). MIDALLOY MASTERCOR E310T0-1/4 may be a better choice of filler metal for dissimilar metal combinations of carbon and low alloy steels to stainless steels for high temperature applications. In addition Midalloy E310T0-1/4 can be heat treated after welding if required without embrittlement,

### TYPICAL CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.20	26.5	21.0	0.05	1.8	0.68	0.02	0.02	0.20

### RECOMMENDED WELDING PARAMETERS

DIA	VOLTS	AMPERAGE (WIRE FEED ipm)	SHIELDING GAS
.045"	24-28	130-200 (250 to 425)	100% CO <sub>2</sub> or 75-25 Argon-CO <sub>2</sub>
1/16"	25-30	180-250 (150 to 250)	100% CO <sub>2</sub> or 75-25 Argon-CO <sub>2</sub>

NOTE: IF USING MIXED GAS, VOLTAGE CAN BE INCREASED BY 2 VOLTS.

### TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	90,200 PSI
YIELD STRENGTH	61,500 PSI
ELONGATION MIN.	34%

### STANDARD SIZES

- .045" and 1/16"

### STANDARD PACKAGING

- 33 lb. spool

12-1-08

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