

MIDALLOY ER310HC BARE WIRE

CLASSIFICATION

- Presently there is no AWS classification for this product.

DESCRIPTION

- Midalloy ER310HC is a bare stainless steel welding wire available in GMAW and GTAW. This product is fully austenitic.

APPLICATIONS

- Midalloy ER310HC stainless steel welding wire is used for welding or repairing high alloy heat and corrosion resistant castings of the same general composition which are designated HK by the alloy castings institute.

TYPICAL CHEMISTRY

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
.35-.45	.90	1.23	.015 max	.010 max	24.4	19.11	.010	.030

TYPICAL MECHANICAL PROPERTIES

Tensile Strength	110,200 PSI
Yield Strength	72,500 PSI
Elongation in 2"	27%

RECOMMENDED WELDING PARAMETERS

PROCESS	DIAMETER	VOLTAGE	AMPERAGE	GAS
TIG	3/32"	15-20	120-175	100% ARGON
MIG	.045"	28-32	180-220	99% AR + 1% OXYGEN

STANDARD PACKAGING

- Tig 10# tube/60# carton
- Mig 25# spool

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