

MIDALLOY ER310 BARE WIRE

CLASSIFICATION

- AWS 5.9 Class ER310/ASME SFA 5.9 Class ER310
- UNS# S31080 A#9 F#6

DESCRIPTION

- Midalloy ER310 is a bare stainless steel welding wire available in GMAW and GTAW. This product is fully austenitic.

APPLICATIONS

- Midalloy ER310 stainless steel welding wire is used for welding stainless steels of similar composition in wrought or cast forms. This product calls for low heat input during welding and can also be used for dissimilar welding.

TYPICAL CHEMISTRY

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
.10	.40	1.68	.015 max	.010 max	25.6	20.6	.07	.13

TYPICAL MECHANICAL PROPERTIES

Tensile Strength	89,500 PSI
Yield Strength	60,500 PSI
Elongation in 2"	34%

RECOMMENDED WELDING PARAMETERS

PROCESS	DIAMETER	VOLTAGE	AMPERAGE	GAS/FLUX*
TIG (GTAW)	1/16"	14-18	90-130	100% Ar
	3/32"	15-20	120-175	100% Ar
	1/8"	15-20	150-220	100% Ar
MIG (GMAW)	.035" SHORT ARC	16-26	70-160	69%Ar-30%He-1%O ₂
	.035" SPRAY ARC	26-31	150-230	92%Ar-8%Co ₂ or
	.045" SPRAY ARC	28-32	180-280	98%Ar-2%O ₂

STANDARD PACKAGING

- Tig 10# tube/60# carton
- Mig 30# spool

10/27/09

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