MIDALLOY MASTERCOR™ E310T1-1/4 FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.22 Class E310T1-1/4 / ASME SFA A5.22 Class E310T1-1/4
- UNS W31031 A#9 F#6

DESCRIPTION

- MIDALLOY MASTERCOR™ E310T1-1/4 is a gas shielded flux-cored wire designed for "all-position" welding and can be used with 75%Ar / 25%CO_2 or 100% CO_2 shielding gas.
- Welding parameters must be optimized to avoid hot cracking.

APPLICATIONS

- MIDALLOY MASTERCOR™ E310T1-1/4 is most often used for welding base metals of similar compositions such as AISI 310 steels.
- MIDALLOY MASTERCOR™ E310T1-1/4 can be used for welding carbon steel to stainless steel.
- MIDALLOY MASTERCOR™ E310T1-1/4 can be used for welding or repairing high alloy heads and corrosion resistant castings of the same general composition.
- Use low heat input – Suggest 30,000 Joules/In Maximum.
- Avoid concave weld beads
- Keep interpass temperature under 250°F
- Fill all start and stop craters to avoid crater cracks.

TYPICAL CHEMISTRY (%)

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
.10	25.9	20.4	.10	1.4	.82	.015	.005	.08

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	89,000 PSI
ELONGATION IN 2"	38%
HEAT TREATMENT	NONE

Note: Mechanical properties shown using 100% CO_2

OPTIMUM TYPICAL WELDING PARAMETERS (using 100% CO_2)

.045" DIA.	FLAT & VERTICAL	FLAT ONLY
AMPS	130-190	120-250
VOLTS	24-29	25-29
WFS (IPM)	225-450	200-600

NOTE: Stick out 3/8"-1/2"
Lower volts by 2 when using 75%Ar / 25%CO_2

STANDARD PACKAGING

- 33 lb. wire basket

6/27/12

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Midalloy