



Techalloy 310

Description

Techalloy 310 is used for the welding of stainless steels of similar composition in wrought or cast form. The weld deposit is fully austenitic and calls for low heat during welding. This filler metal can be used for dissimilar welding and works well in severe corrosive environments such as paper mill machinery.

Specifications & Approvals:

AWS A5.9 ER310

UNS S31080

ISO 14343:2009 (25 20)

CWB

Typical Chemical Composition

C	Mn	Si	Cr	Mo	Ni	Nb	N	S	P	Cu	FN (WRC)
.11	1.90	.40	27.10		20.95			.003	.012		0

Typical Mechanical Properties

Tensile Strength	89,500 PSI	620 MPA
Yield Strength	60,500 PSI	420 MPA
Elongation	34%	

Welding Parameters

	Shielding	Gas Flow	Diameter	Voltage	Amperage
Mig Welding	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO2	30 to 50 CFH	.035" (0.9mm)	26 to 29	160/210
			.045" (1.14mm)	28 TO 32	180/250
			.062" (1.6mm))	29 TO 33	200/280
Tig Welding	100% Argon				
Sub Arc Welding	Suitable flux may be used		3/32" (2.5mm)	28 to 33	275/350
			1/8" (3.14mm)	29 TO 32	350/450
			5/32" (4.0mm)	30 TO 33	400/550

Standard Packages:

Mig Wire– 33# wire basket	Tig Wire– 10# tube/30# Master Carton	SAW– 60# Coil
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