



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 310

Signed by Mats Linde	Approved by Per-Åke Pettersson/Christos Skodras	Reg no EN005050	Cancelling EN004150	Reg date 2009-11-25	Page 1 (1)
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REASON FOR ISSUE

Shielding Gas standard up date.

GENERAL

Bare corrosion resisting chromium-nickel welding rod for welding of heat resistant austenitic steels of the 25Cr-20Ni-type.

The wire has a high Cr content and gives good oxidation resistance at high temperatures. Common applications are industrial furnaces and boiler parts as well as heat exchangers.

Shielding Gas: I1, I2, I3 (EN ISO 14175)

Alloy Type: Fully austenitic (25 % Cr - 20 % Ni)

CLASSIFICATIONS Wire Electrode

EN ISO 14343 W 25 20
SFA/AWS A5.9 ER310

APPROVALS

Not applicable

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.10	0.08	0.15
Si	0.4	0.30	0.65
Mn	1.7	1.4	2.2
P	0.010		0.030
S	0.015		0.020
Cr	25	25.0	27.0
Ni	20	20.0	22.0
Mo			0.30
Cu			0.30
Others tot			0.50

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	
	Min	Typ
Rp0.2 (MPa)	350	390
Rm (MPa)	550	590
A4-A5 (%)	20	43
Charpy V at 20°C (J)		175
Charpy V at -196°C (J)		60

OTHER DATA

Welding should proceed with low heat input (general recommendation max 1.5 kJ/mm).