GWELD
SEAL OF TRUST

GETIG 310

IDENTIFICATION
Getig 310, ER 310

CLASSIFICATION
AWS A 5.9 ER310 BS2901-90 309S94
DIN 8556-86 ~SGX12CrNi 2520

DESCRIPTION

Getig 310 is a solid stainless wire which is primarily intended for welding the 25 % Cr / 20% Ni, type 310, fully austenitic stainless steel used for corrosion and oxidation resistance at elevated temperatures. Deposited weld metal is of radiographic quality.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Cu	Ni	Mo	S	P
0.08 – 0.15	1.0 - 2.50	0.30 - 0.65	25.0 – 28.0	0.50 max	20.0 – 22.5	0.50 max	0.025 max	0.030 max

MECHANICAL PROPERTIES (RANGE)

TS (N/mm2)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
550 - 650	30 - 38	0°C	60 - 100
		-196°C	50 - 80

TYPICAL APPLICATIONS

- For joining difficult to weld steels such as armour plate and ferrite stainless steels as well as dissimilar steels.
- Used for welding in furnace and heat treatment equipment.
- ASTM 310, 310S, CK 20 (Cast) DIN 1.4840 (Cast), 1.4841, 1.4842, 1.4843, 1.4845.

SHIELDING GAS : Argon 99.99% 6-12 l/min

WELDING CURRENT : DC (-)

CORROSION RESISTANCE

Ferrite content in the weld metal: O F N
Designed for high temperature oxidation applications. Its resistance to wet corrosion is limited.

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Packet (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20

2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20
4	1000	5	5 x 4 = 20