

GM 310

IDENTIFICATION

GM 310, ER 310

CLASSIFICATION

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

DESCRIPTION

GM 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 (MPa)	EL (%) (L=4D)
550 - 650	30 - 38

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

WELDING CURRENT : DC (-)

SHIELDING GAS : Ar + 2% O₂ , 16 - 21 l/min

CORROSION RESISTANCE

Designed for high temperature oxidation applications. Its resistance to wet corrosion is limited.

FERRITE CONTENT IN THE WELD METAL : 0 F N

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5 / 15.0
1.2	12.5 / 15.0
1.6	12.5 / 15.0