

# **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: OF 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