



AWS A5.9: ER310  
ISO 14343 2009 25 20

# Stainless Steel Solid Wire

## MIG/TIG Welding

**SW-310**

### DESCRIPTION & APPLICATION

MIG/TIG Filler wire for the joining and overlay of Stainless Steels of similar composition, such as AISI 310 castings. Fully Austenitic deposit makes it Non Magnetic. Resistant to scaling at temperatures up to 1050°C.

### BASE MATERIALS

300 series Austenitic Stainless Steel, Overlay of Mild Steel (Cladding). Furnace and highly corrosive applications. UNS S31000, S31008, S31400. DIN Mat No 1.4841, 1.4845, 1.4840.

### MECHANICAL PROPERTIES

~590n/mm  
**UTS n/mm**

>390  
**YIELD 0.2%**

>40  
**ELONG A5%**

>60  
**CV (J) -196°C**

### METAL WELD COMPOSITION %

**C**

0.11

**Si**

0.4

**Mn**

1.6

**Cr**

25.0

**Ni**

20.5

**S**

0.002

**P**

0.02

**Fe**

BAL

### PACKAGING

15kg Spools (MIG)  
5kg Tubes (TIG)

### DIAMETERS

0.8, 1.0, 1.2mm (MIG)  
1.6, 2.4, 3.2mm (TIG)

### WELDING INSTRUCTIONS

Shielding gas 5% CO<sub>2</sub> in Argon, or 2% Argon-Ox (MIG). 100% Argon (TIG). Do not allow the base material to overheat, maintain interpass temperature below 150°C.