KM-310

Shielding Gas: Ar+1~2%O_2
Ar+1~2%CO_2

Classification

AWS A5.9/A5.9M ER310
AS/NZS ISO 14343 B SS310

Applications and Features

(1) Weld metal is austenite structure with 25%Cr-20%Ni.

(2) Superior corrosion resistance and strength at 1000℃ due to high Ni and Cr content.

(3) Ideal for welding AISI 310S steel and dissimilar metals (carbon steel, Cr-Mo steel and stainless steel).

(4) Also suitable for low temperature and non-magnetic applications.

Welding Instruction

(1) Use Ar blend with 1~2%O_2 for high current, spray transfer welding .

(2) Use Ar blend with 1~2%CO_2 for low current, short-circuit transfer welding..

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Ni
0.086	0.41	2.01	0.010	0.007	27.36	21.55

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2%O_2)

Tensile Strength MPa	Yield Strength MPa	Elongation %
610	480	44

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm) 0.9	1.2
Ar+1~2%CO_2	Amp	60~140	100~210
	Volt	15~21	17~22
Ar+1~2%O_2	Amp	170~260	200~300
	Volt	24~30	24~30

Diam.	15 kg Spool
0.9mm	KM3100915
1.2mm	KM3101215

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