TIGWELD 310

TIG Rods [GTAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : W 25 20 DIN 8556 : SG-X2 CrNi25 20 AWS A-5.9 : ER 310 W.Nr. : 1.4842		Power generation industry Constructions & Engineering Petrochemical and chemical industry

Austenitic welding rods. Recommended for heat resistant steels, pipes and castings with 25% of Cr and 20% of Ni. Suitable also for heat resistant ferritic chromium steels which are not exposed fot the sulfurs compunds. Weld metal is heat resistant up to 1200°C.

Base material

DIN	W.Nr.	AISI/ASME	PN
X15 CrNiSi 20 12	1.4828	309	H20N12S2
X15 CrNiSi 25 20	1.4841	314/310	H25N20S2
X12 CrNi 25 21	1.4845	310S	H23N18
X10 CrAl 24	1.4762	446	H24JS
GX25CrNiSi 18 9	1.4825		
GX40CrNiSi 22 9	1.4826		
GX25CrNiSi 20 14	1.4832		
GX40CrNiSi 25 20	1.4848	HK40	
G-X15 CrNi25 20	1.4840	310	
G-X40 CrNiSi25 12	1.4837		
X10 CrAl7	1.4713		H6S2

Chemical composition %

C	Si	Mn	Cr	Ni
0,12	0,50	1,75	25,00	20,00

Mechanical properties

Yield strength Re [N/mm2]	>300
Tensile strength Rm [N/mm2]	540-640
Elongation A5 [%]	>30
Impact energy Kv [J]	>70J (20°C) /
Shielding gases acc. to EN ISO 14175	I1 - Ar /