GEN 310 Welding Wire and Rod

GEN 310 is most often used to weld base metals of similar chemical composition in wrought or cast form. The weld deposit is fully austenitic. Low heat input is recommended during welding.

CONFORMANCES

AWS A5.9/A5.9M	:	ER310
ASME SFA-A5.9	:	ER310
ISO 14343B	:	SS310

AWS CHEMICAL COMPOSITION *(TYPICAL)*

%C	%Cr	%Ni	%Mo	%Mn
0.08 – 0.15	25.0 – 28.0	20.0 – 22.5	0.75 max	1.0 – 2.5

%Si	%P	%S	%Cu	Total Others
0.30 – 0.65	0.03 max	0.03 max	0.75 max	0.50 max

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	57,000 psi
Tensile Strength	:	87,000 psi
Elongation	:	42 %

TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16”	1.6 mm	14 – 17	80 – 125	100% Ar
	3/32”	2.4 mm	15 – 20	125 – 200	100% Ar
MIG (GMAW)	.035”	0.9 mm	23 – 29	150 – 250	98%Ar – 2%O_2
	.045”	1.1 mm	24 – 30	160 – 270	98%Ar – 2%O_2
Sub Arc (SAW)	.093”	2.4 mm	28 – 32	250 – 450	
	.125”	3.2 mm	29 – 34	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.