



# TIG 310



## Standards

AWS 5.9  
**ER 310**

EN ISO 14343-A  
**W 25 20**

W. Nr.  
**1.4842**

## Description & applications

Filler metal in solid wire sticks for TIG welding of refractory stainless steels type 25-20 used for their very good resistance to oxidation at elevated temperatures, due to their high Chromium content.

Typical applications: heat treatment furnaces, exchangers, etc...

## Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Mo	S max	P Max	Fe
<b>0.15</b>	<b>1.8</b>	<b>0.5</b>	<b>26.0</b>	<b>21.0</b>	<b>0.3</b>	<b>0.02</b>	<b>0.02</b>	<b>Base</b>

## Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV-196°C
<b>600 MPa</b>	<b>400 MPa</b>	<b>35 %</b>	<b>55 J</b>

## Operating parameters

### Shielding gas recommendations :

EN ISO 14175 I1 : 100 % Argon 6 -12 l/mn

Root : Argon, Nitrogen 3 -6 l/mn

