

Standard: AWS A 5.9 YB/T5092	Chemical Composition %								
	C	Mn	Si	Cr	Ni	P	S	Mo	Cu
Grade ER310	0.08–0.15	1.0–2.5	0.3 – 0.65	25 – 28	20 – 22.5	≤0.03	≤0.03	≤0.75	≤0.75
Type	Spool (MIG)				Tube (TIG)				
Specification (MM)	0.8、0.9、1.0、1.2、1.6、2.0				1.6、2.0、2.4、3.2、4.0、5.0				
Package	S100/1kg                      S200/5kg S270,S300/15kg-20kg				5kg/box	10kg/box	length :1000MM		
Mechanical Properties	Tensile Strength Mpa				Elongation after fracture A (%)				
	≥ 550				≥ 30				
Diameter (MM)	0.8	1.0	1.2	1.6	2.0	2.5	3.2		
Current (A)	70 ~ 150	100 ~ 200	140 ~ 220	50 ~ 100	100 ~ 200	200 ~ 300	300 ~ 400		
Application	<p>ER310 is also known as H12Cr26Ni21Si. The melting gold contains 25Cr-20Ni. It is mostly used in the welding ratio KMS of 310S stainless steel. 309 is more suitable for dissimilar metal welding and high self-hardening alloy steel and high carbon steel welding; It can be used for welding stainless steel and stainless steel lining, as well as dissimilar steel, high chromium steel, high manganese steel and so on.</p> <p>The weld metal has good mechanical properties, crack resistance and oxidation resistance, as well as excellent heat resistance and corrosion resistance.</p>								
Notice	<ol style="list-style-type: none"> <li>Oil, dirt and rust on the welding wire surface should be removed before welding. Surface impurities such as oil, rust and water should be thoroughly removed in the welding place, so as to prevent blowhole, crack and so on during welding. The surface of the groove and its surroundings should be polished with metallic gloss.</li> <li>In order to obtain good mechanical properties of welding seam, suggest protect gas Ar+2%O<sub>2</sub> and shield gas flow rate 20-25 L/min for MIG welding. For TIG welding, suggest protect gas pure Ar and shield gas flow rate 8-15 L/min, Arc length 1~3 mm; Length of the tungsten pole is about 3~5 mm; wind speed limit ≤ 1.0 m/s, argon protection at the back of welding area.</li> <li>In the welding process, the welding line energy directly affects the mechanical properties and crack resistance of weld metal, and should be paid more attention to.</li> <li>The above welding methods, conditions and specifications are for reference only. Users should evaluate the welding process according to their own welding characteristics before using the welding wire for the formal product welding.</li> </ol>								