

# RAAJMIG ER 310

## Stainless steel continuous & cut length solid welding wire for MIG/TIG welding

**CLASSIFICATION** : AWS/SFA-5.9: ER310, BS 25.20H  
DIN 8556: WK. 1.4842

**CHARACTERISTICS** : ER310 is fully austenitic Stainless steel welding wire, the weld metal contains ferrite nil and it has excellent resistance to heat.

**APPLICATION** : ER 310 welding wire of 25%Cr-20%Ni steel for joining similar heat restating type steel and particularly suitable for welding carbon steel to 18/8 stainless steel and fully austenite stainless steel for services temperature up to 1100°C and also use for cladding application,

**SHIELDING GAS** : welding with 100% Ar gas Or Ar+2%O<sub>2</sub> gas.

### CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Ni
0.080-0.15.	1.00-2.50	0.30-0.65	0.030 Max	0.030 Max	20.00-22.50
Cr	Mo	Cu			
25.00-28.00	0.75 max.	0.75 Max			

### ALL WELD MECHANICAL PROPERTIES (UNDER Ar GAS SHIELD)

UTS (N/mm <sup>2</sup> )	EL % (5d)	CHARPY "V" NOTCH IMPACT AT +20 <sup>0</sup> C : 50-80 J	FERRITE .(FN)
540-660	30-40	+20 <sup>0</sup> C : 50-80 J	Nil

### DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIGER309)

Size(mm)	Size(inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	√	√	X
1.20	0.047	150-300	24-34	15-25	√	√	√
1.60	1/16"	150-350	28-36	15-30	√	√	√

### DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIGER309)

Size(mm)	Size(inch)	Length (mm)	Length (inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	80-110	10-16	√	√
2.0	5/ 64"	1000	36"	100-150	12-18	√	√
2.4/ 2.5	3/ 32"	1000	36"	130-180	14-20	√	√
3.2	1/ 8"	1000	36"	150-220	16-24	√	√
4.0	5/ 32"	1000	36"	200-280	18-28	√	√

**Raajratna** offer a wide range of Stainless steel welding wires for MIG/TIG/SA welding.

Customer packing on request.