



WB310M M.I.G. WELDING WIRE

Classifications	AWS A5.9-81 : ER310 BSEN12072-00 : G25 20									
Product Description	310 stainless steel, solid MIG wire.									
Applications	<p>WB310M is used mainly for welding and repairing 310 type stainless steels and dissimilar combinations of high temperature steels.</p> <p>The weld deposit can be post-weld-heat-treated without loss of properties. Can be used for welding the following materials:- BS310S24, 310S31 & 310C24, ASTM310, 310S & CK20, DIN 1.4841, 1.4845 & 1.4840. Fully Austenitic weld deposit.</p>									
Wire Composition(Weight %)										
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	
min.	0.08	1.0	0.30	-	-	25.0	20.0	-	-	
max.	0.15	2.5	0.65	0.03	0.03	28.0	22.5	0.5	0.50	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²		550 min.		
	Yield Stress/0.2% Proof Stress					N/mm ²		350 min.		
	Elongation on 5D					%		20 min.		
	Impact Energy CV @ as-welded					Joules		-		

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	300	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	22	26	29	-	-
Packaging Information								
Kg Per Reel		-	15	15	15	15	-	-
Storage	Storage It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
Gases	Gas Pure Argon or Argon + 2%O ₂ mixture Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

