



WB310T T.I.G. WELDING WIRE

Classifications

AWS A5.9-81 : ER310

BSEN12072-00 : G25 20

Product Description

310 stainless steel, solid TIG wire.

Applications

WB310T is used mainly for welding and repairing 310 type stainless steels and dissimilar combinations of high temperature steels.

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.

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
	min.	-	-	-	-	80	80	80
Current Range (Amps)	max.	-	-	-	-	120	120	120
	min.	-	-	-	-	-	-	-
Volt Range (Volts)	max.	-	-	-	-	-	-	-

Packaging Information

Kg Per Tube

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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

Flow Rate

7-10 l/min

Current Conditions DC- and Welding Positions

