

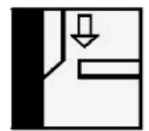
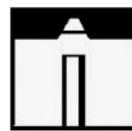
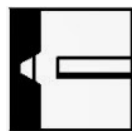
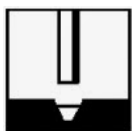


# WB310M MIG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.9:</b> ER310 <b>BS EN ISO 14343-A:</b> G 25 20	
<b>Product Description</b>	310 stainless steel, solid MIG wire.	
<b>Applications</b>	<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 &amp; 310C24, ASTM310, 310S &amp; CK20, DIN 1.4841, 1.4845 &amp; 1.4840. Fully Austenitic weld deposit.</p>	
<b>Wire Composition (Wt. %)</b>		
	C	Mn
<b>min.</b>	0.08	1.0
<b>max.</b>	0.15	2.5
	Si	S
	0.30	-
	0.65	0.03
	P	Cr
	-	25.0
	0.03	28.0
	Ni	Mo
	20.0	-
	22.5	0.5
	Cu	
	-	0.50
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength	N/mm <sup>2</sup> 550 min.
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup> 350 min.
	Elongation on 5D	% 20 min.
	Impact Energy CV @ As welded	Joules -

<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	80	120	160	180	-	-
	<b>max.</b>	-	180	240	280	350	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	17	15	15	20	-	-
	<b>max.</b>	-	20	22	26	30	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	15	15	15	15	-	-
<b>Storage</b>	<b>Storage</b> 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%.							
<b>Gases</b>	<b>Gas</b> Argon + 2%O <sub>2</sub> or Argon + 2-3%CO <sub>2</sub>							
	<b>Flow Rate</b> 15-20 L/min							

### Current Conditions DC+ and Welding Positions



Approvals: CE