

OK Tigrod 310

Bare corrosion resisting chromium-nickel welding rod for welding of heat resistant austenitic steels of the 25Cr-20Ni-type. The wire has a high Cr content and gives good oxidation resistance at high temperatures. Common applications are industrial furnaces and boiler parts as well as heat exchangers.

Specifications

Classifications	EN ISO 14343-A : W 25 20 SFA/AWS A5.9 : ER310
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Alloy Type	Fully austenitic (25 % Cr - 20 % Ni)
Shielding Gas	I1, I2, I3 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	390 MPa (57 ksi)	590 MPa (86 ksi)	43 %

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
20 °C (68 °F)	175 J (129 ft-lb)
-196 °C (-321 °F)	60 J (44 ft-lb)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu
0.10	1.6	0.4	20.7	25.8	0.10	0.05

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr
0.10	1.7	0.4	0.015	0.010	20	25