

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
Approvals	CE : 13479 UKCA : 13479

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Fully austenitic (25 % Cr - 20 % Ni)
Shielding Gas	I1, I2, I3 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	420 MPa	560 MPa	30 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
As Welded	20 °C	230 J
As Welded	-196 °C	130 J

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.10	1.68	0.38	0.001	0.016	20.8	25.8	0.07	0.08

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.10	1.7	0.35	0.001	0.014	20.8	25.6	0.03	0.01