



S. R. Industries

STAR ARC ER310

ER310 type stainless steel wire is used for welding base metal in cast or wrought iron form of similar type stainless steel. The weld deposit calls for low heat during welding and is fully austenitic. This filler metal may also be used for dissimilar welding.

AWS Specification : AWS A5.9/A5.9M:2006

AWS Classification	ER310
Welding Current	DCEP
Typical Wire Chemistry	
C	0.08 - 0.15
Cr	25.0 - 28.0
Ni	20.0 - 22.5
Mo	0.75
Mn	1.0 - 2.5
Si	0.30 - 0.65
P	0.03
S	0.03
Cu	0.75
Typical Mechanical Properties (As Welded)	
Yield Strength, ksi	60
Tensile Strength, ksi	89
Elongation%, min	34
Welding Positions	F,V,OH,H

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<i>Available Diameters MIG with Operating Range in Amps</i>	
<i>.023"</i>	<i>35 - 70</i>
<i>.030"</i>	<i>50 - 100</i>
<i>.035"</i>	<i>160 - 210</i>
<i>.045"</i>	<i>180 - 250</i>
<i>Available Diameters TIG with Operating Range in Amps</i>	
<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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