PRODUCT DATA SHEET

MIG WIRE - PROWELD - 310/ (1.4845)

Classification: AWS / ASME – A/ SFA 5.9 ER 310
BS EN 14343: 2009 – G25 20

Typical Applications:

Proweld 310 is primarily used for welding high temperature austenitic stainless steel of type AISI 310S.
The material offers good scaling resistance in air i.e. up to 1150°C

Wire Composition: (%)

	C	Mn	Si	Cr	Ni	S	P	Mo
min	0.08	1.0	0.3	25	20	-	-	
max	0.15	2.5	0.65	27	22	0.03	0.02	0.75

Mechanical properties (Typical as Weld):

Tensile Strength	590N/mm²
Yield Strength	380 N/mm²
Elongation A5	35%
Impact energy(20° C)	150J
Hardness	180 BHN

Welding Parameter:

Diameter (mm/in.)	Current (A)	Voltage (V)
0.80 / 0.030”	100-160	18-22
1.00 / 0.040”	140-200	18-24
1.20 / 0.045”	170-260	20-28
1.60 /0.060”	220-350	24-36

Welding parameters such as Current, Voltage are just guidelines to users because it depends on application, section thickness of job, design of joints, arc travel speed etc.

Shielding Gas:

M12 Argon+2% CO_2,14-20 L/min
M13 Argon+1-3% O_2,14-20 L/min

Corrosion resistance:

This material used for high temperature application. The corrosion resistance at wet condition is moderate.

Packaging Detail:

Diameter : 0.80, 1.00, 1.20 , 1.60 mm

Packing ** : 12.5Kg (25 lbs), 15Kg (30 – 33lbs) Layer wound plastic spools i.e. SD300, Metallic basket (K300).
5Kg (10lbs) layer wound plastic spools i.e. SD200.
1Kg (2lbs) layer wound plastic spools i.e. SD100.
Drum pack 100 kgs and 250 kgs (0.80, 1.00, 1.20mm)

*Also available in AWS standard diameters.

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