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)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	420 MPa (61 ksi)	560 MPa (81 ksi)	30 %

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 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

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