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technical@daikowelding.comwww.daikowelding.com**DATA SHEET No. E023****DAIKOW 310****MIG – TIG – SAW**

Description / Alloy type: Solid wire for 25%Cr-20%Ni (310) stainless steels.

Specifications: **AWS A5.9** **EN ISO 14343-A**
ER310 25 20

Applications: This consumable is used to weld 310 fully austenitic stainless steels. Applications include heat shields, furnace and boiler parts, heat exchanger and ducting for the good resistance to high temperature oxidation of these alloys.

Also suitable for dissimilar joints, buffer layers, weld overlay and cryogenic applications.

Materials to be welded: **ASTM:** 310 / S31000; 310S / S31008; CK20.
DIN: 1.4841; 1.4842; 1.4840; 1.4845.Composition:
(weight %)

%	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Min	0.08	1.0	0.30	-	-	25	20	-	-
Max	0.15	2.5	0.65	0.020	0.030	27	22	0.3	0.3
Typ	0.10	1.8	0.40	0.005	0.020	26	21	0.1	0.1

Typical parameters:

	TIG	MIG	SAW
Shielding	Argon	Ar + 2% O ₂	Daikoflux
Current	DC-	DC+	DC+
Diameter	2.4 mm	1.2 mm	2.4 mm
Parameters	100A, 12V	180-250A, 28-32V	320A, 30V

All-weld properties:

As welded	Typical
Tensile strength [MPa]	560
Yield strength [MPa]	360
Elongation [%]	40
Impact Energy -196°C [J]	>50

Complementary products: G-Tech 310 SMAW electrode (AWS A5.4 E310-16)
Daiko FCW 310 (AWS A5.22 E310T0-1/4)
Daiko Strip 25.22.2 LMn (AWS A5.9 -EQ310)