

**SUBARC 310**



These consumables are used primarily for welding similar wrought or cast 25%Cr-20%Ni (310) parent alloys with up to 0.25% carbon. Parent metal and weld metal are fully austenitic. The high alloy content of type 310 gives useful oxidation resistance up to peak temperatures of about 1200°C for heat shields, furnace parts and ducting.

**CLASSIFICATIONS**

AWS	A5.9	ER310
BS	EN 12072	25 20
DIN	8556	SG X12CrNi 25 20

**CHEMICAL ANALYSIS**

% Carbon	0.110	% Chromium	26.00
% Manganese	1.800	% Nickel	21.00
% Silicon	0.400	% Molybdenum	0.100
% Sulphur	0.005	% Copper	0.100
% Phosphorus	0.020		

**TYPICAL MECHANICAL PROPERTIES  
ALL WELD METAL**

<b>Tensile Strength</b>	540 MPa
<b>0.2% Proof Stress</b>	355 MPa
<b>Elongation on 4d</b>	27%
<b>Impact Energy -196°C</b>	70J

**Microstructure**  
Fully austenitic. Typical magnetic permeability < 1.01.

\* Flux Dependant

**PACKING DATA**

SAW Wire (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.40	320	30	078-157	25
3.20	400	32	078-158	25

Suggested flux : Afrox Flux DX-9

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