



# Cromatig 310

GTAW - TIG  
Stainless Steel

Date: 2008-01-22  
Revision: 8

## Description:

Cromatig 310 is primarily intended for welding the 25% Cr / 20% Ni type 310 fully austenitic stainless steels, used for corrosion and oxidation resistance at elevated temperatures. Suitable also for joining difficult-to-weld steels such as armour plate and ferritic stainless steels as well as dissimilar steels.

## Welding current:

DC-

## Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min	0,08	0,30	1,0			24,0	18,0
Typical	0,11	0,40	1,6	0,020	0,010	25,5	20,5
Max	0,15	0,65	2,5	0,030	0,020	27,0	22,0

	Mo	Cu
Min		
Typical	0,10	0,10
Max	0,30	0,30

## Shielding gas:

Acc. to EN 439:

I1, Ar 99.99%, 6-12 l/min

## Corrosion resistance

Designed for high temperature oxidation applications and its resistance to wet corrosion is limited.

## Scaling temperature:

1150°C in air. Reducing combustion gas, free of sulphur 1080°C, maximum 2g S/m<sup>3</sup> 1040°C.

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,11	0,4	1,5	0,02	0,01	25,0	20,0
Max							

	Mo
Min	
Typical	0,10
Max	

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 300 MPa	390 MPa
Tensile Strength, Rm:	≥ 550 MPa	590 MPa
Elongation, A5	≥ 30%	40%
Impact energy, CV:		20°C • 170 J -196°C • 60 J

## Classification:

EN ISO 14343 W 25 20  
AWS A5.9 ER310

## Approvals:

## Product data

Diam.mm	Length mm	Product code
1,6	1000	9806-1016
2,0	1000	9806-1020
2,4	1000	9806-1024
3,2	1000	9806-1032