

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.

Classifications	EN ISO 14343-A : W 25 20 SFA/AWS A5.9 : ER310
------------------------	--

Alloy Type	Fully austenitic (25 % Cr - 20 % Ni)
-------------------	--------------------------------------

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	390 MPa	590 MPa	43 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	175 J
As Welded	-196 °C	60 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu
0.10	1.6	0.4	20.7	25.8	0.10	0.05

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr
0.10	1.7	0.4	0.015	0.010	20	25