



**GMAW / GTAW STAINLESS STEEL**

**MIGINOX 310 / TIGINOX 310**

25Cr/20Ni TYPE STAINLESS STEEL SOLID WIRE



**CLASSIFICATION :** EN ISO 14343-A      AWS A/SFA 5.9

Miginox 310: G 25 20      ER310  
Tiginox 310: W 25 20      ER310

**KEY FEATURES :**

- A 25Cr/20Ni type austenitic stainless steel wire
- Resistance to cracking and fissuring
- Excellent oxidation resistance upto 1150°C
- Radiographic quality welds

**WELDING POSITION :**



**GMAW: DCEP**  
**GTAW: DCEN**

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
GMAW: 98Ar/2O <sub>2</sub> or Ar/1-5CO <sub>2</sub>	15-25	10-20
GTAW: Ar	10-15	-

**TYPICAL APPLICATIONS :**

- Welding of AISI 310 type steels, Austenitic Mn steels
- Joining of dissimilar steels, straight chrome steels, cladding side of stainless clad steels
- Furnace parts, Annealing boxes, Carburizing pots, Gas turbine combustion chamber parts, hydrogenation and polymerization plant

**STORAGE / HANDLING :**

Keep dry and follow handling instructions mentioned on the box

**CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :**

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.08-0.15	1.0-2.5	0.30-0.65	25.0-28.0	20.0-22.5	0.75 max	0.03 max	0.03 max

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

	Condition	UTS, MPa	EL%
Specification	As Welded	550 min	30 min

Mechanical properties will vary with the type of shielding gas used.

**PACKING DATA :**

Miginox 310	Ø, mm		Kg/Spool	
	1.2		12.5	
	1.6		12.5	
Tiginox 310	Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
	1.6 x 1000	5	4	20
	2.0 x 1000	5	4	20
	2.5 x 1000	5	4	20

**EQUIVALENT :**

SMAW Electrode: **Betanox C**