

# MIGINOX 310 / TIGINOX 310

## Classification

AWS A/SFA 5.9 : ER 310

## Characteristics

This filler is used for MIG welding of heat resistant austenitic alloys of 25Cr-20Ni types. The alloy has good general oxidation resistance at high temperatures.

## Typical Applications

Suitable for welding of stainless steel type AISI 310, austenitic manganese steel, for joining of dissimilar steels, straight chrome steels and cladding side of stainless clad steels. Used in the manufacture of equipment for hydrogenation and polymerization plant, gas turbine combustion chamber parts, annealing boxes etc.

### Typical Wire Chemistry

C	Mn	Si	Cr	Ni	S	P
0.08-0.15	1.0-2.5	0.30-0.65	25.0-28.0	20.0-22.5	0.030 max	0.030 max

Properties of weld metal with 98% Ar + 2% O<sub>2</sub> gas Current Condition : DC (+) in GMAW

### All Weld Mechanical Properties As welded condition

UTS MPa	550 mm
Elongation % (L=4xd)	30 mm
The chemistry & mechanical properties of the weld will vary with the type of shielding gas used.	

### Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 12.5 Kg

### Packing Specifications for MIGINOX 310

Size mm	2.0	1.6	1.2	0.80
Kgs	12.5	12.5	12.5	12.5

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

### Packing Data for TIGINOX 310

Dia., mm	1.6	2.0	2.5
Length,mm	1000	1000	1000
Net wt per tube,kg	5	5	5
No of Plastic Tubes per Box	4	4	4
Net wt,Box,kg	20	20	20



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