

# ES TIG 310

GTAW

ER310

**ESWECO**  
*The Art of Welding*

## Description

Bare, corrosion-resistant, chromium-nickel welding rod for welding heat-resistant austenitic steels of the 25Cr-20Ni type.

The wire has a high Cr content and provides good oxidation resistance at high temperatures. Common applications include industrial furnaces and boiler parts, as well as heat exchangers.

## Current

DC (-)

## Classifications

SFA/AWS A5.9      ER310  
EN 12072          W 25 20

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.1	0.5	1.8	26.0	21.0	<0.3	<0.3

## Typical mech. Properties all weld metal

Yield stress, MPa                      390  
Tensile strength, MPa                590  
Elongation, %                         43

## Charpy V

Test temps, °C      Impact values, J  
                         +20                      175  
                         -196                      60

## Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0