

Applications

MIG welding of 25%Cr-20%Ni stainless steel, welding on the clad side of stainless clad steel.
 Welding of dissimilar metals.

Characteristics on Usage

SM-310 has full austenitic structure.

Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Ni
0.09	0.35	1.90	26.8	20.9

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
610 (88,500)	40

Typical Welding Conditions (DC+)

Size mm(in)	A	V	Speed (cm/min.)	Gas Flow (ℓ /min.)	Remarks
1.2 (.045)	250	26	30	25	Shielding gas
1.6 (1/16)	300	29	35	25	100%Ar or Ar+2%O ₂