

Gas Metal Arc Welding

JIS Z3321 Y310
AWS A5.9 ER310
DIN 8556-SG 1.4842

MS M-310 Solid Wires for Stainless Steel

Applications Suitable for welding of similar composition (26.5%Cr21%Ni) or clad part of 18%Cr-8%Ni stainless steel. Owing to the high contents of alloying elements, ductility maintained in welding of carbon steel where deposited metal is diluted by base metal steel.

Brand Name		MS M-310							
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.15	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	20.0-22.5	25.0-28.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm ²								
0.2% Offset strength	≥ 225 N/mm ²								
Elongation	≥ 35 %								
Impact test	NA								
Welding position	Horizontal/Flat position								
Welding polarity	DC-EP								
Shielding gas	98%Ar - 2%O ₂								
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm				
	80-180A	120-200A	140-250A	170-300A	200-350A				
Packing	12.50 kgs standard other packing weight can be provided upon request.								