

NON-MAGNETIC 310

The weld deposit is fully austenitic and calls for low heat during welding.

APPLICATION

Non-Magnetic 310 is used for welding of stainless steels of similar composition in wrought or cast form. This filler metal can also be used for dissimilar welding.

SPECIFICATION

MECHANICAL PROPERTIES

Tensile Strength (psi)	89,500 PSI/620 MPA
Yield Strength (psi)	60,500 PSI/420 MPA
Elongation %	34%

WELDING PARAMETERS

MIG Welding Direct Current; Electrode +Ve

Shield Gas	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO ₂
Gas Flow	30 to 50 CFH
Voltage	29 to 33
Amperage	160/180 for .035" (0.9mm) 180/220 for .045" (1.14mm) 210/250 for .062" (1.6mm)

T.I.G. Welding Direct Current; Electrode -Ve

Shield Gas	100% Argon
Gas Flow	30 to 40 CFH

SUB-ARC Welding Direct Current; Electrode +Ve

Voltage	29 to 32
Amperage	300 to 350 for 3/32" (2.5 mm) 400 to 550 for 1/8" (3.14 mm) 500 to 650 for 5/32" (4.0 mm)
Speed of Welding	20 to 30 IPM (500 to 750 mm)/min.

NOMINAL COMPOSITION

C.....0.06-0.15	Fe.....Balance
Si.....0.45-0.75 max.	Mn.....0.90-1.40
Ni.....0.15 max.	P.....0.025 max.
Mo.....0.15 max.	V.....0.30 max.
Co.....0.50 max.	Others.....0.50 max.
S.....0.035 max.	
Cr.....0.15max.	

PACKAGING

Available in 28 and 10 lb. spools, 55 lbs. coils, 100, 250 & 500 lbs. pay-off-packs



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