

## OK Tigrod 310

Bare corrosion resisting chromium-nickel welding rod for welding of heat resistant austenitic steels of the 25Cr-20Ni-type. The wire has a high Cr content and gives good oxidation resistance at high temperatures. Common applications are industrial furnaces and boiler parts as well as heat exchangers.

Specifications	
<b>Classifications</b>	EN ISO 14343-A : W 25 20 SFA/AWS A5.9 : ER310
<b>Approvals</b>	CE : 13479 UKCA : 13479

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type</b>	Fully austenitic (25 % Cr - 20 % Ni)
<b>Shielding Gas</b>	I1, I2, I3 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	420 MPa ( 61 ksi )	560 MPa ( 81 ksi )	30 %

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C ( 68 °F )	175 J ( 129 ft-lb )
-196 °C ( -321 °F )	60 J ( 44 ft-lb )

Typical Weld Metal Analysis %								
C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.10	1.7	0.35	0.001	0.014	20.8	25.6	0.03	0.01

Typical Wire Composition %								
C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.10	1.68	0.38	0.001	0.016	20.8	25.8	0.07	0.08