

**CODIFICATION: AWS/SFA 5.9: ER310**

**CHARACTERISTICS AND APPLICATIONS:**

FW 310 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. The weld metal has excellent resistance to oxidation and scaling up to 1200°C. It is ideally suited for the welding of similar and dissimilar compositions, including hardenable steels, clad steels, Carbon - Molybdenum and Chromium - Molybdenum steels where pre-heat, and post weld heat treatments are impracticable.

**TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:**

Element	C	Mn	Si	S	P	Cr	Ni
Percent	0.10	2.0	0.50	0.015	0.018	26.0	21.0

**TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:**

UTS (MPa)	Elongation (L=4d) %
600	32.0

**SHIELDING GAS : Argon**

**CURRENT CONDITIONS : DCEN**

**WELDING POSITION : H, F, VU, OH**

**PACKING:**

<b>STANDARD SIZE</b>	Diameter 1.6 mm 2.0 mm, 2.50 mm & 3.20 mm in cut lengths of 1000 mm each.
<b>QUANTITY</b>	5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire.

**An ISO 9001: 2008 certified company**

**D & H Sécheron Electrodes Pvt. Ltd.**

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