

DESCRIPTION

Executive 310 wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up.

By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 310 provides a fully austenitic weld. In fully austenitic welds maintaining a low heat input is critical to avoid hot cracking.

APPLICATIONS & FEATURES

Executive 310 is used in furnaces, ducting, and general manufacturing and fabrication.

Executive 310 is used to weld base metals of similar composition and for dissimilar stainless welding. Executive ER310 is often the filler metal of choice when the stainless base is an unknown grade.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N	
0.098	26.72	20.65	0.11	1.56	0.38	0.022	0.001	0.13	0.023	
Tensile Strength:		88,400 PSI min		Yield Strength:		69,600 PSI min		Elongation:		41%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
GMAW - Short	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar	
	.045"	22-23	180-210			
	.062"	23-24	200-220			
	- Spray	.035"	23-25			190-260
		.045"	25-28			250-330
		.062"	28-31			310-350
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
SAW	.093"	29-32	300-350		Record IND 24 or Record IN	
	.125"	29-32	400-550			

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER310**
Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.

