



TIG 25/20

Old reference: TIG 310

Classification

AWS A5.9 : ER310

ISO 14343-A : W 25 20

Description & Applications

Solid rod for GTAW of similar austenitic steels like 310. Also well adapted for welding of dissimilar steels like high temperature resistant steels and austenitic stainless steels. Good resistance against oxidation at high temperature up to 1000°C.

Main applications: Petrochemical industry, papers factory, ovens, boilers...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co
Min	0.08	0.30	1.0	25.0	20.0			-			-
Max	0.15	0.65	2.5	27.0	22.0	0.5	0.5	-	0.03	0.02	-
Type	0.10	0.45	1.7	26.0	20.5	0.10	0.10	0.01	0.02	0.01	0.06

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	350	550	30	-
Max				-
Type	380	580	40	+20°C 170

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 l/min Back shielding: I1 (Ar) / N1 (Nitrogen) : 3-6 l/min

Back shielding with Argon or Nitrogen gas or with copper backing support to avoid "back end" rust phenomena.

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