

INCO-WELD® 310 is used for the welding of stainless steels of similar composition in wrought or cast form. The weld deposit is fully austenitic and calls for low heat during welding. This filler metal can also be used for dissimilar welding.

### \*Typical Chemical Analysis (%)

Element	%	AWS Requirement
Carbon (C)	0.095	0.08-0.15
Chromium (Cr)	25.57	25.0-28.0
Nickel (Ni)	20.60	20.0-22.5
Molybdenum (Mo)	0.070	0.75 max
Manganese (Mn)	1.680	1.0 to 2.5
Silicon (Si)	0.410	0.30-0.65
Phosphorus (P)	0.016	0.03 max
Sulphur (S)	0.001	0.03 max
Copper (Cu)	0.130	0.75 max

### \*Typical Mechanical Properties

Tensile Strength	89,500 psi
Yield Strength	60,500 psi
Elongation	34%

### \*Typical GMAW welding Parameters

	Wire Diameter	Amperage	Voltage	Shielding
Short Circuit	.035"	80-160	14-22	90% He + 7½% Ar + 2½ O2
	.045"	110-220	15-23	90% He + 7½% Ar + 2½ O2
	.062"	130-250	16-23	90% He + 7½% Ar + 2½ O2
Spray Transfer	.035"	175-250	23-26	Ar + 2% O2
	.045"	225-325	24-29	Ar + 2% O2
	.062"	300-425	26-30	Ar + 2% O2

### Approvals

AWS A5.9 ER310  
ASME SFA 5.9  
CWB

### Available Sizes and Packaging

GMAW	
Diameter	Packaging
.035	30 lb. Spools/ Wire Baskets
.045	

\*All information listed is provided as typical values and may differ from actual results due to variations in weld procedures. IAI disclaims any liability resulting from reliance on any of the above values.

## Controlled Products Group

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