

## OK Autrod 310

A continuous, solid, corrosion-resistant, chromium-nickel wire for welding heat-resistant austenitic steels of the 25% Cr, 20% Ni types. OK Autrod 310 has good general oxidation resistance, especially at high temperatures, due to its high Cr content. The alloy is fully austenitic and is therefore sensitive to hot cracking. Common applications include industrial furnaces and boiler parts, as well as heat exchangers.

<b>Classifications Wire Electrode:</b>	EN ISO 14343-A:G 25 20, SFA/AWS A5.9:ER310
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<b>Alloy Type:</b>	Fully austenitic (25 % Cr - 20 % Ni)
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### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	390 MPa	590 MPa	43 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As welded	20 °C	175 J
As welded	-196 °C	60 J

### Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu
0.10	1.6	0.4	20.7	25.8	0.10	0.05

### Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	50-140 A	16-22 V	3,4-11 m/min	0,8-2,7 kg/h
1.0 mm	80-190 A	16-24 V	2,9-8,4 m/min	1,1-3,1 kg/h
1.2 mm	180-280 A	20-28 V	4,9-8,5 m/min	2,6-4,5 kg/h
1.6 mm	230-350 A	24-28 V	3,2-5,5 m/min	3-5,2 kg/h