

## 310 LMo Tig

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Manganese alloyed chromium-nickel-molybdenum filler material

**APPLICATIONS** The weld deposit has excellent low temperature toughness that makes it suitable for joining stainless steels for cryogenic service

**PROPERTIES** 310 LMo has been developed primarily to cope with the severe corrosion conditions existing in the urea industry. Therefore, this filler has excellent resistance to corrosion in ammonium carbamate and nitric acid

**CLASSIFICATION**

AWS	A 5.9: ER 310LMo
EN ISO	14343-A: 25 22 2 N L
DIN: W.Nr.	1.4466

**SUITABLE FOR** Heat resistant stainless steels, UNS S31050, 1.4466, UNS S31603, 1.4435

**APPROVALS** CE approved

**WELDING POSITIONS:**



### WELD METAL ANALYSIS

C	Si	Mn	P	S	Cr	Ni	Mo	N
		4.5			25	22	2.1	0.13

### MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HV
				+20°C	-40°C	-196°C	
AW	335	580	42	120		100	170

AW: as welded

### WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters Current (A) DC-	Packing (kg)	
		single	master
1.6 x 1000	50-80	5	25
2.0 x 1000	70-110	5	25
2.4 x 1000	110-180	5	25
3.2 x 1000	150-250	5	25

**REDRYING TEMPERATURE** Not required

**GAS ACC. EN ISO 14175:** I1