



**MANUFACTURERS OF A DIVERSE RANGE OF
ADVANCED WELDING CONSUMABLES**

**SECTION
13**

WI-0304 DS169 NSB-310R, Rev. 0, Date 01.09.2008

NSB-310R	FILLER ROD FOR WELDING FULLY AUSTENITIC STAINLESS STEELS CONTAINING A NOMINAL 25Cr-20Ni					DATA SHEET NO. 169				
						AWS A5.9		JIS Z 3321		
SPECIFICATION	AWS A5.9		JIS Z 3321			BS EN 12072				
CLASSIFICATION	ER310		Y310			W 25 20				
WELD METAL ANALYSIS COMPOSITION % BY Wt.	C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Fe
	MIN	0.08	25	20		1.0	0.30	-	-	-
	MAX	0.15	28	22.5	0.75	2.5	0.65	0.03	0.03	0.75
	TYPICAL	0.1	27	21	0.05	1.5	0.45	0.02	0.02	0.1
WELD METAL PROPERTIES (ALL WELD METAL)	<u>PROPERTY</u>		<u>UNITS</u>		<u>MINIMUM</u>		<u>TYPICAL</u>		<u>OTHERS</u>	
	Tensile strength		N/mm ²		550		575			
	0.2% Proof stress		N/mm ²				380			
	Elongation on 4d		%		30		40			
	Impact energy -75 °C		J		-		120			
OTHER DATA	Argon mainly use as shielding gas									
RELATED PRODUCTS	Please contact our Technical Department for detail.									