WILKINSON STAR

WELD STAR®

ER 310

Stainless Steel WIRE/GMAW

Standards

EN/ISO-Standard - 14343-A
EN/ISO-Classification - G 25 20

AWS-Standard - A5.9
AWS-Classification - ER 310

Features and Applications

- Rutile flux cored stainless steel wire for gas-shielded arc welding.
- 23% chromium - 9% nickel - 3% molybdenum - nitrogen - low carbon duplex stainless steel deposit.
- Exceptional resistance to moisture pick-up.
- Attractive bead appearance, very good penetration and high productivity.
- Excellent X-ray soundness.
- Maximum performance in the flat and horizontal positions.
- Ideal for heterogeneous welding between duplex stainless steels and other stainless and mild or low alloyed steels.
- Precision layer wound for superior wire feeding characteristics.
- Suitable for wrought, forged or cast duplex stainless steels for service in the as-welded condition.
- **Test Certificates can be found online @wilkinsonstar247.com**

Approvals

CE, UKCA

Typical Base Materials

300 series austenitic stainless steel for welding (e.g. AISI 310, 304); mild and carbon steels for overlay works*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - M12, M13

Polarity

DC (+)

Welding Parameters - M12

Ø mm	0.80	1.00	1.20
Current (A)	40-120	80-160	100-210
Voltage (V)	15-20	16-22	17-23

Welding Parameters - M13

Ø mm	0.80	1.00	1.20
Current (A)	160-210	180-280	200-300
Voltage (V)	24-28	25-30	26-32

Mechanical Properties

Tensile Strength (N/mm^2)	Yield Strength (N/mm^2)	Elongation (%)
≥550	≥350	≥20

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition % (Typical)

C %	Mn%	Si %	S %	P %	Ni %	Cr %	Mo %	Cu%
0.096	1.65	0.35	0.006	0.025	20.07	26.80	0.060	0.25

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
6011100230	0.80	15	D300 PLW	72
6011100232	1.00	15	D300 PLW	72
6011100234	1.20	15	D300 PLW	72