

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GFW310E

Applicable Specification

JIS Z3323 TS310-FC0
AWS A5.22 E310T0-1

● Applications and Characteristics

TASETO GFW310E is used for welding of AISI310 or SUS310S, and for welding of dissimilar metals such as stainless steel and carbon steel combination. Weld metal has excellent corrosion resistibility and heat resistance, because of higher content of Cr and Ni compared with Type 308 weld metal.

● Notes on Usage

- * Please refer “Guideline for Welding Stainless Steel with GFW Wires”.
- * Because of fully austenitic structure of weld metal, the weld metal susceptibility of hot cracking is high. So, welding current must be kept within 150~200A. In the case of high restrained condition, it must be kept within 150~170A. Keep the interpass temperature at 120°C or below. To minimize crater crack, fill craters with filler metal and remove crater crack with grinder.
- * Use 100%CO₂ as shielding gas.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.170	0.45	2.03	0.022	0.003	20.63	25.40	0.04	0.03

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	391	592	37.0

● Sizes Available and Shielding Gas

Size (mm)	Shielding Gas
1.2	100%CO ₂ , 20L/min