



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

USA 310 Welding Wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

310 is used for welding types AISI 310, 304 clad stainless steel, ferritic and martensitic chromium steels, and for stainless steel overlay work on mild and carbon steels. 310 welding wire produces weld deposits of high strength and high resistance to scalling at elevated temperatures.

(Tri-mix gas = 90%He+7.5%Ar+2.5%CO₂)

TYPICAL GMAW WELDING PROCEDURES; DCEP Short Circuit

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stick-out	Tri-mix (cfh)
0.023	180-400	30-85	14-19	3/8-1/2"	20-25
0.030	150-350	45-125	15-20	3/8-1/2"	20-25
0.035	120-330	60-150	16-22	3/8-1/2"	20-30
0.045	100-280	90-210	17-22	3/8-1/2"	25-30
<i>Spray 0.030</i>	<i>280-600</i>	<i>160-220</i>	<i>24-28</i>	<i>3/8-1/2"</i>	<i>(1)25-35</i>
<i>0.035</i>	<i>250-470</i>	<i>170-295</i>	<i>23-29</i>	<i>1/2-3/4"</i>	<i>(1)25-35</i>
<i>0.045</i>	<i>200-385</i>	<i>195-360</i>	<i>24-30</i>	<i>1/2-3/4"</i>	<i>(1)30-35</i>
<i>1/16"</i>	<i>110-200</i>	<i>210-380</i>	<i>25-31</i>	<i>1/2-3/4"</i>	<i>(1)35-40</i>

⁽¹⁾ 98%Ar
2%O₂

TYPICAL GTAW WELDING PROCEDURES; DCEN with EWTh-2 truncated conical tip

Filler Wire Size	Tungsten	Amps	Volts	Gas Cup Size	Argon (cfh)	Base thickness
1/16"	1/16"	80-150	12	3/8"	20	1/16-1/8"
3/32"	3/32"	150-250	12	3/8"	20	1/8- 3/16"
1/8"	1/8"	200-375	12	1/2"	25	1/4-1/2"

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	0.14	Nickel	21.10
Manganese	1.80	Chromium	27.00
Silicon	0.50		

AVAILABLE SIZES: TS 310= Spools of .023, 035, 045, 1/16
TT 310 = Cut lengths of 030, 035, 045, 1/16, 3/32, 1/8, 5/32, 3/16

SPECIFICATIONS; ANSI/AWS A5.9 ER310
ASME SFA 5.9 ER310

EAST COAST
825 Groves St
Lowell, NC 28098
Tel (980) 550-2002
Fax (909) 291-4586

GULF COAST
4855 Alpine Drive #100
Stafford, TX 77 477
Tel (888) 522-8296
Fax (909) 291-4586

WEST COAST
8885 White Oak, Ste104
Rancho Cucamonga, CA 91730
Tel (888) 522-8296
Fax (909) 291-458



Warehouse Distribution Center – Dallas/Fort Worth & Portland, Oregon & Boston, Massachusetts Head Office – Puyallup, Washington

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