

INERTFIL 310 is a G25 20/ER 310 solid MAG welding wire, supplied precision layer wound, depositing a C-25Cr 20Ni weld metal. Suitable for use with Ar+2%O₂ or Ar+0.5...5%CO₂ mixed shielding gases.

INERTFIL 310 weld metal has high temperature ductility and excellent resistance to oxidation at working temperatures <1000°C. It is used for the welding of 310 austenitic stainless steel pipe, plate and fittings used in the fabrication of furnaces and similar applications working at elevated temperatures. It is used mainly for heat exchangers and hot water boilers.

INERTFIL 310 weld deposit is fully austenitic.

Solid wire for stainless steels, designed to weld type AISI 301 steels. Excellent corrosion resistance even when hot.

Classification	
EN	14343-A: G 25 20
AWS	A5.9: ER 310

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni
0.12	1.8	0.6	≤ 0.020	≤ 0.020	26	21

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
As Welded	≥350	≥550	≥30	≥70


Gas test: 98% Ar+2% O₂

Shielding Gas - EN ISO 14175 : M12, M13

Materials

AISI 310; 1.4845 (X8CrNi25-21); 1.4841 (X15CrNiSi25-21); 1.4828 (X15CrNiSi20-12)

Storage
Keep dry and avoid condensation

Current condition and welding position
DC+

PA PB PC PD PE PF PG

Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
0.8	W000283114
1.0	W000283115
1.2	W000283116