



Supplier of Welding Alloys

Stainless Steel Flux Cored Wire

Oxford Alloy® 310T-1

SPECIFICATIONS

AWS 5.22
ASME SFA 5.22

CLASSIFICATIONS

AWS E310T1-1/T1-4
UNS W31031

DESCRIPTION / APPLICATION

Oxford Alloy E310T1-1/4 is a gas shielded flux cored wire designed for all position welding. It can be run with either 75% Ar / 25% CO2 or 100% CO2 shielding gas. It is normally used for welding materials of similar composition such as AISI 310 steel. It may also be used for welding carbon steel to stainless steel and also for welding or repairing high alloy heads and corrosion resistant castings with the same general composition. No heat treatment is required.

Typical Chemical Composition						
C	Mn	Si	Cr	Ni	Mo	P
0.10	1.4	0.82	25.9	20.4	0.10	0.015
S	Cu					
0.005	0.08					

TYPICAL MECHANICAL PROPERTIES
100% CO2

Tensile strength: 89,000
PSI Elongation:
38 %

Optimum Welding Parameters (100% CO2)		
.045 DIA	Flat & Vertical	Flat Only
AMPS	130 - 190	120 - 250
VOLTS	24 - 29	25 - 29
WFS (IPM)	225 – 450	200 - 600

Stick out: 3/8" – 1/2"
Volts should be lowered by 2 when using 75% Ar/25%CO2

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

Data contained in this publication are typical of the products and properties described, but are not suitable for specifications.
OXFORD ALLOYS is a registered trademark of Oxford Alloys, Inc.