Unibraze 310-16

CLASSIFICATIONS: AWS A5.4/ASME SFA 5.4 Class E310-16 UNS W31010

DESCRIPTION: Unibraze 310-16 is an austenitic,25Cr/20Ni, all position stainless steel electrode, used to weld AISI 310 AND AISI 310S. Heat treatment is not required.

Typical Chemistry:

	C	Cr	Ni	Mo	Mn	Si	P	S	Cu
AWS/ ASME	.08 – .20	25.0-28.0	20.0-22.50	.75 max	1.0 - 2.5	.75 max	.03 max	.03 max	.75 max
Typical	.11	27.3	21.07	.016	1.90	.40	.010	.010	.09

Typical Mechanical Properties:

	AWS/ASME	Typical
Tensile Strength	80,000 psi (550 MPa) min.	84,557 psi (583 Mpa)
Yield Strength	Not required	63,000 psi (434 Mpa)
Elongation	30% min.	39%

Suggested Operating Range (AC or DC+)

Dia.	F/H Fillet	V-up/OH
3/32”	50~85	45~85
1/8”	80~120	70~110
5/32”	100~150	100~150
3/16”	140~200	---

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