



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 | --- |

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus, the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.