



# MIG 25/20

Old reference: MIG 310

## Classification

ISO 14343-A : G 25 20  
 AWS A5.9 : ER310

Material N° : ~1.4842

## Description & Applications

Solid wire for joining of similar austenitic steels (310 ...). Well adapted for welding of dissimilar steels as heat resistant steels to stainless steels. Also suitable for welding high temperature resistant steels for service temperatures up to about 1000°C.

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.1	0.45	1.7	26.0	20.5	0.1	0.1	<0.02	<0.01	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )	
390	600	40	+20°C	120
			-196°C	60

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	100-150	22-27	Ar + 2%CO <sub>2</sub> Ar + 1%O <sub>2</sub> 18-20 l/min
	1.0	120-200	24-28	
	1.2	140-220	24-28	
	1.6	180-260	24-30	

Ind.10



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