



exocor™

Stainless Steel BARE WIRE DATA SHEET

executive 310

DESCRIPTION

Executive 310 is usually used to weld base metals of similar composition. The weld deposit is fully austenitic and is therefore more sensitive to hot cracking. Caution should be taken to minimize heat input during welding. This filler metal can also be used for dissimilar welding.

TYPICAL CHEMICAL VALUES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.1	26.5	21.0	0.2	1.8	0.4	0.02	0.02	0.75

WELDING PARAMETERS

PROCESS	SIZE	VOLTS	AMPS	SPEED OF WELDING / GAS FLOW	SHIELDING GAS / FLUX
SAW	.093	29 - 32	300 - 350	20 - 30 IPM	Record IN Flux
	.125	29 - 32	400 - 550	20 - 30 IPM	Record IN Flux
	.156	29 - 32	500 - 650	20 - 30 IPM	Record IN Flux
GMAW	.035	29 - 33	160 - 180	30 - 50 CFH	98/99% Ar + 2/1% O ₂
	.045	29 - 33	180 - 220	30 - 50 CFH	or
	.062	29 - 33	210 - 250	30 - 50 CFH	97% Ar + 3% CO ₂
GTAW	.093	Direct Current; Electrode -		30 - 40 CFH	100% Ar

MECHANICAL PROPERTIES

Tensile Strength: 89,500 PSI 620 MPA
Yield Strength: 60,500 PSI 420 MPA
Elongation: 34%

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.9, Class ER310**, ISO 14343A, Class 25 20 and ISO 14343B, Class SS310.