



Unibraze 310T-1

All Position

Classification: AWS A5.22 Class E310T1/1/4/ASME SFA 5.22 Class E310T1-1/4 UNS W31031 A#9 F#6

Description: Unibraze 310T-1 is a gas-shielded, flux cored, stainless steel electrode used to weld in all positions with 100% CO₂ or 75% Ar/25% CO₂ shielding gas. Unibraze 310T-1 welds AISI 310 steels, carbon steel to stainless steels, high alloy heads and corrosion resistant casting of similar composition. Avoid concave beads. Use low heat input – 30,000 Joules/In maximum. Keep interpass temperature under 250°F. Fill all start and stop craters to avoid crater cracking.

Diameters: .045"

Shielding Gases: 100% CO₂, 75% Ar/25% CO₂,

Welding Positions: All positions

Typical Mechanical Properties: (CO₂)

Tensile Strength (psi)	89,000 PSI
Percent Elongation	38 %

Typical Weld Deposit Chemistry: (CO₂)

C	Mn	Cr	Si	Ni	Mo	Si	Cu	P	S
.10	1.4	25.9	.82	20.4	.10	.82	.08	.015	.005

Typical Welding Parameters: (CO₂)

	Diameter	WFS (IPM)	Amperage	Voltage
Flat/Vertical	.045"	225-450	130-190	24-29
Flat	.045"	200-600	120-250	25-29

Lower voltage by 2 when using 75% Ar/25% CO₂

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.