Unibraze 310T-1
(Modified Chemistry)

Classification: ISO 17633-A T 25 20 P C 2 / ISO 17633-A T 25 20 P M21 2

Description: Unibraze 310T-1 is a gas-shielded, all position, flux cored, stainless steel electrode used to weld AISI 301, 302, 304, 305, and 308 stainless steels, and carbon steels to stainless steels. It is also used for welding and repair of high alloy heads and corrosion resistant castings of similar composition. The increased Mn content in **Unibraze 310T-1** provides excellent weldability and improved crack resistance. Shielding Gases: 100% CO_2, 75% Ar/25% CO_2.

Typical Chemical Composition% (CO_2)

	C	Cr	Ni	Mo	Mn*	Si	P	S	Cu
ISO 17633-A	.06 - .20	23.0 – 27.0	18.0 – 22.0	.30 max	1.0 – 5.0	1.2 max	.03 max	.025 max	.50 max
Typical	.12	26.62	20.14	.13	4.40	.71	.019	.01	.21

***AWS A5.9 Mn =1.0-2.5**

Typical Mechanical Properties (CO_2)

	ISO 17633-A	Typical
Tensile Strength	79770 psi (550 MPa)	86152 psi (594 MPa)
Yield Strength	50,700 psi (350 MPa)	55,695 psi (384 MPa)
Elongation	20% min.	38%

Suggested Mechanical Properties (CO_2 DC^+)

	Amps	Volts
F/H – Fillet	100-300	20-36
V/OH	100-200	24-30

Note: Lower volts by 2 for 75% Ar/25% CO_2

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.