

Technical Data Sheet

315T TIG Wire



Cronatron™
A LAWSON BRAND



Overview

315T TIG Wire is formulated with extra moly to provide increased strength in the as-deposited and stress-relieved conditions. In addition, high levels of manganese and silicon serve as deoxidizers that make it suitable for welding through light rust and scale with good wetting action. Its high strength makes it ideal for welding medium- to high-carbon steels and low alloy steels. Weld deposits are extremely tough, making it a good choice for cold weather applications. 315T TIG Wire meets the requirements of AWS specifications.

Features/Benefits

- Very high strength
- High silicon and manganese for cleansing action
- Excellent wetting action
- Torch cuttable
- Extremely high impact properties
- Copper flashed to prevent corrosion
- High elongation

Applications

- Auto frames
- Steel vessels
- Steel piping
- Structural members
- Medium-to-high carbon steel applications

Method of Application

Gas tungsten arc welding (GTAW), DC straight polarity; Electrode: DC reverse polarity

Identification

TIG: Embossed/flagged; Electrode: Gray printed

Directions for Use

Use DC straight polarity (electrode: DC reverse polarity). A gas lens collet body is recommended for optimum wetting action and cleaning. Use pure argon gas with pressure set at 15 to 20 cfh. (0.42 to 0.55 m³/hr.)

Technical Specifications

Tensile Strength: 111,000 PSI (765 MPa)
Yield Strength: 95,000 PSI (655 MPa)
Elongation: 22%
Impact Properties as welded at -20°F (-29°C): 87 ft.-lbs. (118 J)
Gas: 100% Ar