CEWELD 310LMo Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Manganese alloyed chromium-nickel-molybdenum filler material(Type 25 22 2 L)

APPLICATIONS

CEWELD 310LMo Tig weld deposit has excellent low temperature toughness that makes it suitable for joining stainless steels for cryogenic service

PROPERTIES

CEWELD 310LMo Tig has been developed primarly to cope with the severe corrosion conditions existing in the urea industry. Therefore, this filler has excellent resistance to corrosion in ammonium carbamate and nitric acid

CLASSIFICATION

AWS	A 5.9: ~ER 310
EN ISO	14343-A: W 25 22 2 N L
F-nr	6
FM	5
W.Nr.	1.4466

SUITABLE FOR

ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21-30
1.4335 , 1.4435 1.4465 , 1.4466, 1.4577
X1CrNi25-21, X2CrNiMo18-14-3, X1CrNiMoN22-25-3, X1CrNiMoN25-22-2, X3CrNiMoTi25-25
UNS S31050, S31603
AISI 316L, 725LN, 310MoLN
Sandvik 2RE69, Sandvik 3R60 U. Sandvik 3R60 G, Uranus 25 22 2, 2RE69, 3R60U.G (Sandvik),Cronifer 25.25.LCN

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.05	0.5	4.5	0.01	0.01	26	22	2.1

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	Impact Energy (J) ISO-V -196°C	Hardness Vickers
As Welded /	335	580	42	120	100	Avg. 170

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

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CEWELD 310LMo Tig

310LMO TIG 2,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663416070

310LMO TIG 2,4 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663416117

310LMO TIG 3,2 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663416193