CEWELD 310 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

High heat resistant stainless steel welding wire for Tig welding.(Type 25 20)

APPLICATIONS

Common applications include industrial furnaces, annealing chambers, fused salt treatment installations and boiler parts, as well as heat exchangers.

PROPERTIES

Solid drawn ,corrosion-resistant, chromium-nickel wire for welding heat-resistant austenitic steels of the 25% Cr, 20% Ni types. 310 has good general oxidation resistance, especially at high temperatures, due to its high Cr content. The alloy is fully austenitic and is therefore sensitive to hot cracking. The temperature limits for use under intermittent oxidation depend on cycle frequency. In no case shall a temperature of 1000°C be exceeded. This alloy can withstand relatively severe thermic shock, and is superior to type 309 L.

CLASSIFICATION

AWS	A 5.9: ER310
EN ISO	14343-A: W 25 20
F-nr	6
FM	5
W.Nr.	1.4842

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type: 25% Cr, 22%Ni
1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4823, 1.4826, 1.4828, 1.4832, 1.4835,1.4837, 1.4840, 1.4841, 1.4845, 1.4846, 1.4848, 1.4849, 253MA,
X15CrNiSi 25 20, G-X40CrNiSi 25 12, G-X15CrNi 25 20, X8CrNi25-21
AISI 305, 310, 314 ASTM A297 HF / A297HJ

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.1	0.5	1.8	0.01	0.01	26	21	0.3	0.3

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	-196°C	-40°C
As Welded /	405	575	45	130	45	65

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

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	Type	KG/unit	EANCode
310 TIG 1,0 X 1000MM	Tube	5	8720663416124
310 TIG 1,6 X 1000MM	Tube	5	8720663416131
310 TIG 2,0 X 1000MM	Tube	5	8720663416148
310 TIG 2,4 X 1000MM	Tube	5	8720663416155
310 TIG 3,2 X 1000MM	Tube	5	8720663416162