



# CEWELD AA 310

TYPE	Rutile flux cored stainless steel welding wire for M21 and Co2 gas. ( Type 25 20 )									
APPLICATIONS	Common applications include industrial furnaces, annealing chambers, fused salt treatment installations and boiler parts, as well as heat exchangers									
PROPERTIES	For welding heat-resistant austenitic steels of the 25% Cr, 20% Ni types. AA 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 309L.									
CLASSIFICATION	AWS	A 5.22: E310T0-1	AWS	A 5.22: E310T0-4	EN ISO	17633-A: T 25 20 R C1 3	EN ISO	17633-A: T 25 20 R M21 3		
	F-nr	6	FM	5	W.Nr.	1.4842				
SUITABLE FOR	<b>ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type: 25% Cr, 22%Ni</b> 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	PA	PB	PC	PF						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C 0.18	Si 0.6	Mn 2.1	P 0.015	Cr 25.5	Ni 21	S 0.015			
ALL WELD MECHANICAL PROPERTIES	Heat Treatment As Welded /	R <sub>P0,2</sub> MPa 410	R <sub>m</sub> MPa 600	A <sub>5</sub> (%) 35	Impact Energy (J) ISO-V RT 75					
REDRYING TEMPERATURE	140°C / 24 hr									
GAS ACCORDING EN 14175	M21, C1									



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AA 310 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663416094