



CEWELD AA 310B

TYPE	Basic flux cored stainless steel welding wire for M21 and M20 gas																
ANWENDUNGEN	Common applications include industrial furnaces, annealing chambers, fused salt treatment installations and boiler parts, as well as heat exchangers Especially where rutile flux cored wire gives a to high risk for cracking this basic type is a better choice																
EIGENSCHAFTEN	For welding heat-resistant austenitic steels of the 25% Cr, 20% Ni types. AA 310B 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																
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: E310T0-4</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 25 20 B M21 3</td> </tr> <tr> <td>W.Nr.</td> <td>1.4842</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.22: E310T0-4	EN ISO	17633-A: T 25 20 B M21 3	W.Nr.	1.4842	F-nr	6	FM	5						
AWS	A 5.22: E310T0-4																
EN ISO	17633-A: T 25 20 B M21 3																
W.Nr.	1.4842																
F-nr	6																
FM	5																
GEEIGNET FÜR	<p>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</p>																
ZULASSUNGEN	CE																
SCHWEISSPOSITIONEN																	
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">C</td> <td style="width: 25%;">Si</td> <td style="width: 25%;">Mn</td> <td style="width: 25%;">Cr</td> <td style="width: 25%;">Ni</td> </tr> <tr> <td>0.1</td> <td>0.5</td> <td>2.5</td> <td>25.5</td> <td>21</td> </tr> </table>	C	Si	Mn	Cr	Ni	0.1	0.5	2.5	25.5	21						
C	Si	Mn	Cr	Ni													
0.1	0.5	2.5	25.5	21													
MECHANISCHE GÜTEWERTE	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> <tr> <td>As Welded</td> <td>400</td> <td>590</td> <td>30</td> <td colspan="2">80</td> <td>HRc</td> </tr> </table>	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT		As Welded	400	590	30	80		HRc
Heat Treatment	R _{p0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness						
		RT															
As Welded	400	590	30	80		HRc											
RÜCKTROCKNUNG	Not required																
GAS ACC. EN ISO 14175	M20, M21																