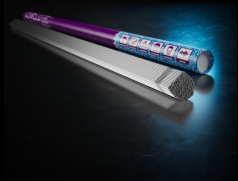


# CEWELD 310 Tig

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	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER310</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: W 25 20</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 5.9: ER310	EN ISO	14343-A: W 25 20	W.Nr.	1.4842	F-nr	6	FM	5									
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EN ISO	14343-A: W 25 20																			
W.Nr.	1.4842																			
F-nr	6																			
FM	5																			
SUITABLE FOR	<b>ISO 15608: 8.1 Austenitic ≤ 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																				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.5</td> <td>1.8</td> <td>0.01</td> <td>0.01</td> <td>26</td> <td>21</td> <td>0.3</td> <td>0.3</td> </tr> </tbody> </table>	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	
C	Si	Mn	P	S	Cr	Ni	Mo	Cu												
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MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>p0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-196°C</th> <th>-40°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>405</td> <td>575</td> <td>45</td> <td>130</td> <td>45</td> <td>65</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness	RT	-196°C	-40°C	As Welded	405	575	45	130	45	65	HRc
Heat Treatment	R <sub>p0,2</sub> (MPa)					R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness									
		RT	-196°C	-40°C																
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REDRYING	Not required																			
GAS ACC. EN ISO 14175	I1																			



# CEWELD 310 Tig

310 TIG 1,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416124

310 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416131

310 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416148

310 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416155

310 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416162