CEWELD AA 310

certilas® THE FILLER METAL SPECIALIST

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, A 5.22: E310T0-4
EN ISO	17633-A: T 25 20 R C1 3, 17633-A: T 25 20 R M21 3
W.Nr.	1.4842
F-nr	6
FM	5

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 WELD METAL (%)

C	Si	Mn	P	Cr	Ni	S
0.18	0.6	2.1	0.015	25.5	21	0.015

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	410	600	35	75	HRc

REDRYING: 140°C / 24 hr

GAS ACC. EN ISO 14175: M21, C1

CEWELD AA 310

AA 310 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663416094