



# 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                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | A 5.9: ER310            |                      |                    |                         |        |       |          |     |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 14343-A: W 25 20        |                      |                    |                         |        |       |          |     |
|                                                   | 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<br>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, GX40CrNiSi22-10, X15CrNiSi20-12, 310, 310S, CK20, 305, 314, 725LN, 316L ASTM A297 HF / A297HJ<br>UNS: S31000, S31008, S31050, S31603                                                                                                                                                                         |                         |                      |                    |                         |        |       |          |     |
| APPROVALS                                         | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                         |                      |                    |                         |        |       |          |     |
| WELDING POSITIONS                                 | <div>PAPBPCPDPEPFPG</div> |                         |                      |                    |                         |        |       |          |     |
| 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 |
| MECHANICAL PROPERTIES                             | 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      |     |
| 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 |