


Technical data sheet <small>011121MBA</small>	Cored welding wire TUBE S 310-S	
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CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	EC310
ASME IIC SFA 5.9 / AWS A 5.9:	EC310
EN ISO 17633-A:	T 25 20 M NO 3
Equivalent Material number:	1.4842
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Metal cored stainless steel wire for submerged arc welding
- Maximum diameter 1.6 mm to limit heat input
- 25% chromium - 20% nickel deposit
- Enhanced productivity, improved weldability, better wetting properties compared to solid wires
- Excellent weld metal quality and X-ray soundness

APPLICATIONS

TUBE S 310-S is resistant to oxidation and scaling up to 1100°C; it is suitable for welding stainless steels of similar composition and heat resistant ferritic alloys

Examples:

AISI	UNS	Material number	EN Symbol
310	S31000	1.4841	X15 CrNiSi 25-21
310S	S31008	1.4845	X12 CrNi 25-21

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	S	P
0.15	3.00	0.70	26.0	21.0	0.008	0.020

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A5 [%]	CVN [J]
630	420	30	+ 20°C: 80

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

PACKAGING

Diameter	1.6 mm
Standard packaging	EN ISO 544 - ASME IIC SFA-5.2 M
	Coil: B450
Weight	25 kg

Other packaging and other diameters: please consult us