

**Technical data sheet**

011121MBA

**Cored welding wire**  
**TETRA S B 310-G****CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	E310T0-4
EN ISO 17633-A:	T 25 20 B M21 3
EN ISO 17633-B:	TS310-F M21 0
Equivalent Material number:	1.4842

ASME IX Qualification QW432 F-N° 6 QW442 A-N° 9

**DESCRIPTION**

- Basic flux cored stainless steel wire with high-alloy strip for gas shielded arc welding
- 25% chromium - 20% nickel deposit
- Exclusive slag system and fine tuning of the compositional balance insure maximum resistance to hot cracking under restraint
- Attractive weldability
- Excellent X-ray soundness, ductility and impact toughness
- Maximum performance in the flat and horizontal positions
- Welded with classical economic Ar-CO<sub>2</sub> mixtures

**APPLICATIONS**

TETRA S B 310-G is resistant to oxidation and scaling up to 1100°C.

It is suitable for welding stainless steels of similar composition, especially in those applications where solid wires or rutile welding consumables are unsuitable due to cracking.

Joining of 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	Bi	S	P
0.10	2.5	0.5	25.5	21.0	< 0.002	0.008	0.020

**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
550	350	25	+20°C: 47

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
590	400	30	+20°C: 80

**SHIELDING GAS**M21 (Ar + 15 - 25% CO<sub>2</sub>) or M20 (Ar + 5% < CO<sub>2</sub> ≤ 15%) gas mixtures according to EN ISO 14175**OPERATING CONDITIONS**

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	100 - 220	18 - 30	12 - 25	10 - 20 l/min.
1.6	DC+	150 - 300	22 - 30	12 - 25	10 - 20 l/min.

**WELDING POSITIONS**

Flat, Horizontal

**PACKAGING**

Diameter	1.2 mm		1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M		
Spool type	S200	BS300	BS300
Weight	5 kg	15 kg	15 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.