

Technical data sheet

EN140923GB

Cored welding wire
TETRA V 310-G**CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	E310T1-4 - E310T1-1
EN ISO 17633-A:	T 25 20 P M21 1 - T 25 20 P C1 1
EN ISO 17633-B:	TS310-F M21 1
Equivalent Material number:	1.4842

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

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 25% chromium - 20% nickel deposit
- Attractive bead appearance, very good penetration and high productivity
- Excellent X-ray soundness
- Specifically designed for out-of-position welding
- Maximum productivity for completion of vertical welds
- Welded with classical economic Ar-CO₂ mixtures or CO₂

APPLICATIONS

TETRA V 310-G is resistant to oxidation and scaling up to 1100°C. It is suitable for welding cast or wrought stainless steels of similar composition and heat resistant ferritic stainless steels.

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
0.10	2.5	0.5	25.0	20.0	0.008	0.020

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
550	350	30	+20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
600	410	35	+20°C: 60

SHIELDING GAS

M21 (Ar + 15 - 25% CO₂), M20 (Ar + 5% < CO₂ ≤ 15%) gas mixtures or C1 (CO₂) according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	130 - 270	22 - 35	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

PACKAGING

Diameter	1.2 mm		
	EN ISO 544 – ASME IIC SFA-5.2 M		
Spool type	S200		BS300
Weight	5 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.