

Technical data sheet

EN030724GB

Cored welding wire
TUBE S 310-S**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

* Manganese content may exceed 2.5 %.

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

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.