


CEWELD SA 310

TYPE	High heat resistant stainless steel welding wire for submerged arc welding																
APPLICATIONS	Common applications include industrial furnaces, annealing chambers, fused salt treatment installations and boiler parts, as well as heat exchangers..																
PROPERTIES	SA 310 is a corrosion-resistant, chromium-nickel wire for welding heat-resistant austenitic steels of the 25% Cr, 20% Ni types. He 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. This wire can be welded with our fused flux FL 880 of agglomerated flux FL 838																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER310</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: S 25 20</td> </tr> <tr> <td>W.Nr.</td> <td>1.4842</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.9: ER310	EN ISO	14343-A: S 25 20	W.Nr.	1.4842	F-nr	6	FM	5						
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SUITABLE FOR	ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type: 25% Cr, 22%Ni 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 AISI 305, 310, 314 ASTM A297 HF / A297HJ																
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WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.5</td> <td>1.8</td> <td>0.02</td> <td>0.02</td> <td>26</td> <td>21</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	0.1	0.5	1.8	0.02	0.02	26	21		
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		RT	-196°C														
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REDRYING	Not required																
GAS ACC. EN ISO 14175																	



CEWELD SA 310

SA 310 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663416186