CEWELD® SA 310

CATEGORY	SAW Arc Submerged
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		
	AWS	A 5.9: ER310
	EN ISO	14343-A: S 25 20
	F-nr	6
	FM	5
	W.Nr.	1.4842

SUITABLE FOR	1.4823, 1.4826, 1.4828, 1.4832, 1.4835, 1.4840, 1.4841, 1.4846, 1.4848, 1.4837, 1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4845, 1.4849, 253MA, X15CrNiSi 25 20, G-X40CrNiSi 25 12, G-X15CrNi 25 20, X8CrNi25-21 AISI 305, 310, 314 ASTM A297 HF / A297HJ
APPROVALS	CE
WELDING POSITIONS:	

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni
0.1	0.5	1.8	0.02	0.02	26	21

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	Impact Energy (J) ISO-V -196°C
As Welded /	390	590	39	165	55

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOL TYPE	KG / SPOOL	KG / PALLET
1,6	27-30	200-300	K-415	25	1000
2,4	29-33	300-400	K-415	25	1000
3,2	29-33	350-500	K-415	25	1000
4,0	30-36	400-600	K-415	25	1000

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	