



# CEWELD 310L Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                           |                         |                      |                    |          |    |
|---------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|-------------------------|----------------------|--------------------|----------|----|
| TYPE                                              | High heat resistant stainless steel welding wire for Tig welding.(Type 25 /20)                                                                                                                                                                                                                                                                                                                                                                                       |                           |                         |                      |                    |          |    |
| APPLICATIONS                                      | Common applications include heavily oxidizing media such as pipes in preheaters, coolers and condensers in the chemical industry.                                                                                                                                                                                                                                                                                                                                    |                           |                         |                      |                    |          |    |
| PROPERTIES                                        | 310L has very good resistance to intergranular corrosion, pitting and stress corrosion cracking due to its high chromium and nickel contents.                                                                                                                                                                                                                                                                                                                        |                           |                         |                      |                    |          |    |
| CLASSIFICATION                                    | AWS<br>W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                         | A 5.9: ~ER 310<br>~1.4842 |                         |                      |                    |          |    |
| SUITABLE FOR                                      | <b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type: 25% Cr, 22%Ni</b><br>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, GX40CrNiSi22-10, X15CrNiSi20-12, 310, 310S, CK20, 305, 314, 725LN, 316L ASTM A297 HF / A297HJ<br><b>UNS: S31000, S31008, S31050, S31603</b> |                           |                         |                      |                    |          |    |
| APPROVALS                                         | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                           |                         |                      |                    |          |    |
| WELDING POSITIONS                                 |                                                                                                                                                                                                                                                                                                                                                                                     |                           |                         |                      |                    |          |    |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Si                        | Mn                      | P                    | S                  | Cr       | Ni |
|                                                   | 0.02                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 0.2                       | 1.6                     | 0.01                 | 0.01               | 25       | 21 |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                           | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |    |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                           | 400                     | 600                  | 35                 | HRc      |    |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                           |                         |                      |                    |          |    |
| GAS ACC. EN ISO 14175                             | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                           |                         |                      |                    |          |    |