



# 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..                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                         |                      |                    |                         |        |          |
| PROPRIÉTÉS                                           | 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        |                      |                    |                         |        |          |
|                                                      | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 1.4842                  |                      |                    |                         |        |          |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 6                       |                      |                    |                         |        |          |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 5                       |                      |                    |                         |        |          |
| CONVIENT POUR                                        | ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type: 25% Cr, 22%Ni<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>UNS: S31000, S31008, S31050, S31603                                                                                                                                                                                |                         |                      |                    |                         |        |          |
| AGRÉMENTS                                            | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                         |                      |                    |                         |        |          |
| POSITIONS DE SOUDAGE                                 | <div>  </div>                                                                                                                                                                                                                                                                                                                                                                |                         |                      |                    |                         |        |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Si                      | Mn                   | P                  | S                       | Cr     | Ni       |
|                                                      | 0.1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.5                     | 1.8                  | 0.02               | 0.02                    | 26     | 21       |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                         |                      |                    | RT                      | -196°C |          |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 390                     | 590                  | 39                 | 165                     | 55     | HRc      |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |                    |                         |        |          |
| GAS ACC. EN ISO 14175                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                         |                      |                    |                         |        |          |



# CEWELD SA 310

SA 310 2,4MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| K-415     | 25      | 8720663416186 |