



FCW 310

High productivity 310 type
Flux cored wire

Classification

AWS A5.22 : ~E310T0-1/-4

ISO 17633-A : T 25 20 R M21(C1) 3

Description & Applications

Flux cored wire for gas shielded (Ar + CO₂) arc welding for 310 type stainless steel and adapted for welding dissimilar steels as heat resistant steels to stainless steels. Deposit resisting to corrosion and oxidation up to 1100°C and against hot cracks. High deposit rate in flat position. Could be used in positions.

Main applications: Ovens, boilers, thermal equipment for heat treatment, chemical and petrochemical installations.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.12	0.50	2.40	24.0	20.5	0.25	0.10	0.02	0.008	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
410	600	35	+20°C 60

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar/CO ₂) 12 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	

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