



# FCW 310LP

310 type Flux cored wire  
For all positions

## Classification

AWS A5.22 : ~E310T1-1/-4

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

## Description & Applications

Flux cored wire for gas shielded (Ar + CO<sub>2</sub>) 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. Mainly used for welding 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
0.10	0.50	2.50	25.0	20.0	0.30	0.10	0.02	0.008	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> ( % )	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	130 - 270	22 - 35	12 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 10 - 20 l/min

FT En-CN12-160211



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