



# 310 FCW-PW

EN ISO 17633-A: T 25 20 P M21/C1 1

AWS A5.22: E310T1-4 – E310T1-1

1.4842

## DESCRIPTION

Rutile flux cored stainless steel wire for gas shielded arc welding with 25Cr and 20Ni deposit. Specifically designed for out-of-position welding, maximum productivity for completion of vertical welds. For heat resisting applications where the weld metal has a scaling temperature up to 1100°C.

### WELDING POSITIONS



### CURRENT

DC +

### GAS

Ar/Co2(M21)

## BASE MATERIALS

310 (1.4841), 310S (1.4845)

## MECHANICAL PROPERTIES

<i>R<sub>m</sub></i> (Mpa)	<i>R<sub>p 0,2</sub></i> (Mpa)	A5 (%)	KV(j)
600	410	30	+20°C: 47

## WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Ni	S	P	
0,1	2,5	0,5	25,0	20,0	0,008	0,02	

## PACKAGING AND WELDING PARAMETERS

Dimension (mm)	1,2	For positions: PA,PB	1,2
Volt (V)	23-32		29-30
Ampere(A)	100-250		210-230
Stick out (mm)	12-25		15
Gas flow (l/min)	10-20		17
Wire feeding (m/min)	9-12		10-11

## EQUIVALENT FILLER METALS

MMA	Meltolit 310 E
TIG	Meltolit 310 XT
MIG	Meltolit 310 XM