



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
Min	0.06		1.0	23.0	18.0				
Max	0.20	1.2	5.0	27.0	22.0	0.3	0.5	0.030	0.025
Type	0.12	0.50	2.4	24.0	20.5	0.25	0.10	0.020	0.008

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	350	550	20	
Max				
Type	410	580	30	+20°C 50

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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