



FCW 310LP

310 type Flux cored wire
For all positions

Classification

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

ISO 17633-A : T 25 20 P M21(C1) 1

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. 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 |
|------|------|------|-----|------|------|------|------|-------|-------|
| 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 | 0.10 | 0.50 | 2.5 | 25.0 | 20.0 | 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 | 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 ₂) 10 - 20 l/min |



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