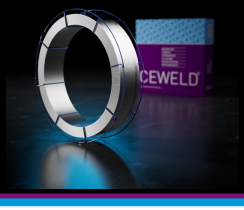


CEWELD SA 310

certilas® THE FILLER METAL SPECIALIST

TYPE

High heat resistant stainless steel welding wire for submerged arc welding

APPLICATIONS

Common applications include industrial furnaces, annealing chambers, fused salt treatment installations and boiler parts, as well as heat exchangers..

PROPERTIES

SA 310 is a corrosion-resistant, chromium-nickel wire for welding heat-resistant austenitic steels of the 25% Cr, 20% Ni types. He has good general oxidation resistance, especially at high temperatures, due to its high Cr content. The alloy is fully austenitic and is therefore sensitive to hot cracking. The temperature limits for use under intermittent oxidation depend on cycle frequency. In no case shall a temperature of 1000°C be exceeded. This alloy can withstand relatively severe thermic shock, and is superior to type 309 L. This wire can be welded with our fused flux FL 880 of agglomerated flux FL 838

CLASSIFICATION

AWS	A 5.9: ER310
EN ISO	14343-A: S 25 20
W.Nr.	1.4842
F-nr	6
FM	5

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type: 25% Cr, 22%Ni
1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4823, 1.4826, 1.4828, 1.4832, 1.4835,1.4837, 1.4840, 1.4841, 1.4845, 1.4846, 1.4848, 1.4849, 253MA,
X15CrNiSi 25 20, G-X40CrNiSi 25 12, G-X15CrNi 25 20, X8CrNi25-21, GX40CrNiSi22-10, X15CrNiSi20-12,
310, 310S, CK20, 305, 314, 725LN, 316L ASTM A297 HF / A297HJ
UNS: S31000, S31008, S31050, S31603

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni
0.1	0.5	1.8	0.02	0.02	26	21

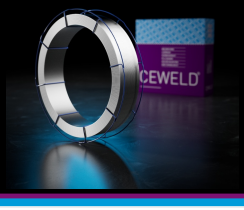
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	390	590	39	165	55	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175



CEWELD SA 310

SA 310 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663416186