MIGWELD 310

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 25 20 DIN 8556 : SG-X10 CrNi25 20 AWS A-5.9 : ER 310 W.Nr. : 1.4842		Power generation industry Constructions & Engineering Metallurgy (Steelworks) Petrochemical and chemical industry

- Austenitic wire used for welding heat-resistant steels, pipes and castings made of 25% Cr and 20% Ni heat-resistant steels, as well as for welding ferritic heat-resistant steels and chromium steels that are not exposed to sulfur compounds.
- The joint is resistant to elevated temperatures up to 1200°C.

Application

Typical applications include high-temperature furnaces, radiant pipes, steam boilers, internal components of coal gasifiers, thermowells, burners, combustion chambers, retorts, muffs, food processing equipment, cryogenic structures, fans, pipes. Pharmaceutical and chemical industry. It is used in equipment for continuous casting of steel, used in ore and steel processing plants, catalytic recovery systems, oil refining industry, sinter plants, cement plants, annealing casings and boxes, fans.

Base material

W.Nr	EN 10088-1/2	AISI/ASME
1.4745	G-X40 CrSi23	
1.4823	G-X40 CrNiSi27 4	
1.4832	G-X25 CrNiSi20 14	
1.4833	X7 CrNi23 14	309S
1.4837	G-X40 CrNiSi25 12	
1.4840	G-X15 CrNi25 20	
1.4841	X15 CrNiSi25 20	310
1.4845	X12 CrNi25 21	310S
1.4762	X10 CrAl24	
1.4821	X20 CrNiSi25 4	
1.4772	X10 CrSi29	
1.4825	G-X25 CrNiSi18 9	
1.4826	G-X40 CrNiSi22 9	
1.4828	X15 CrNiSi20-12	309
1.4848	G-X40 CrNiSi25 20	
1.4713	X10 CrAl7	

Typical chemical composition %

C	Si	Mn	Cr	Ni
0,12	0,50	1,75	25,00	20,00

Typical mechanical properties

Yield strength Re [N/mm2]	>300
Tensile strength Rm [N/mm2]	540-640
Elongation A5 [%]	>30
Impact energy Kv [J]	>70J (20°C) /

Wire/rod type	solid
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	M12 - Ar + 0.5 - 5% CO2 /

Welding parameters and packing

ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	100-160	18-22	15,0
1,0	140-200	18-24	15,0
1,2	170-260	20-28	15,0
1,6	220-350	24-36	15,0

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