

# FLUXINOX 310

## Cored Wires Stainless and Heat resistant steels

Fluxinox 310 is an alloyed rutile flux cored wire for the joining of heat resistant Cr and Cr-Ni steels and cast steel. The weld metal is fully austenitic and non-scaling up to 1200 °C. It is not resistant to sulphur-bearing gases. Fluxinox 310 features outstanding, almost spatter-free, welding properties with very easy slag removal, finely rippled and shiny weld beads which are free of undercut into the base metal.

| Classification |                                      |
|----------------|--------------------------------------|
| AWS            | A5.22: E 310T0-G                     |
| EN             | 12073: T 25 20 R M 3 / T 25 20 R C 3 |

| Approvals | Grades |
|-----------|--------|
|-----------|--------|

### Analysis of all-weld metal (Typical values in %)

| C    | Mn   | Si   | P | S | Cr | Ni | Mo | Nb | Cu | N | Ferrite |
|------|------|------|---|---|----|----|----|----|----|---|---------|
| 0.10 | 2.50 | 0.55 | - | - | 25 | 20 | -  | -  | -  | - | -       |

### All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>A5 (%) | Impact Energy<br>ISO - V (J)<br>+20 °C | Hardness |
|----------------|-------------------------------------|---------------------------------------|----------------------|--|----------|
| As Welded      | ≥ 350                               | ≥ 550                                 | ≥ 30                 | ≥ 40                                   | -        |

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

### Materials

AISI 310; 1.4845 (X8CrNi25-21); 1.4841 (X15CrNiSi25-21); 1.4828 (X15CrNiSi20-12)

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 kg. 16

|           |     |  |  |  |  |  |
|-----------|-----|--|--|--|--|--|
| Diameters | 1,2 |  |  |  |  |  |
|-----------|-----|--|--|--|--|--|