

# FLUXINOX 310-PF

## Cored Wires Stainless and Heat resistant steels

Fluxinox 310-PF is an alloyed rutile flux cored wire with a fast-freezing slag for the welding of heat resistant Cr and Cr-Ni steels and cast steels. The weld metal is fully austenitic and non-scaling up to 1200 °C. It is not resistant to sulphur-bearing gases. Fluxinox 310-PF exhibits outstanding, almost spatter-free, welding properties with very easy slag removal, finely rippled and shiny welds which are free of undercut. Fluxinox 310-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
AWS	A5.22: E 310T1-G
EN	12073: T 25 20 P M 1 / T 25 20 P C 1

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 N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) +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+**



PA PB PC PF PE

**Packaging data:** K300 kg. 16

Diameters	1,2					
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