WT-310

For 25%Cr-20%Ni stainless steel

AWS A5.22 E310T0-1/4
JIS Z3323 TS 310-FB1

Applications

WT-310 is designed for MAG welding of 310S stainless steels.

Characteristics on Usage

- WT-310 is a rutile type flux cored wire for flat and horizontal position welding.
- It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- The weld metal provide better weldability together with superior heat resistance, and corrosion resistance.

Notes on Usage

- The shielding gas should be used 100%CO_2 or Ar+20~25%CO_2 for welding.
- Gas flow rate is proper 20~25ℓ/min.

Sizes Available and Recommended Currents (DC +)

Dia(mmØ)	Current(A)	Voltage(V)	Electrode extension(mm)
1.2	130~200	25~33	10~20
1.6	170~250	25~33	15~25

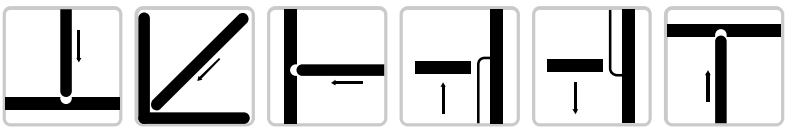
Typical Chemical Composition of All-Weld-Metal (wt%) (Shielding gas : MIX)

C	Mn	Si	P	S	Cr	Ni	Mo
0.05	1.83	0.61	0.020	0.006	25.5	21.1	0.08

Typical Mechanical Properties of All-Weld-Metal (Shielding gas : MIX)

Y.P MPa	T.S MPa	EL(%)	IV J (-20℃)
470	610	34	45

Welding positions



Approved by

JIS