

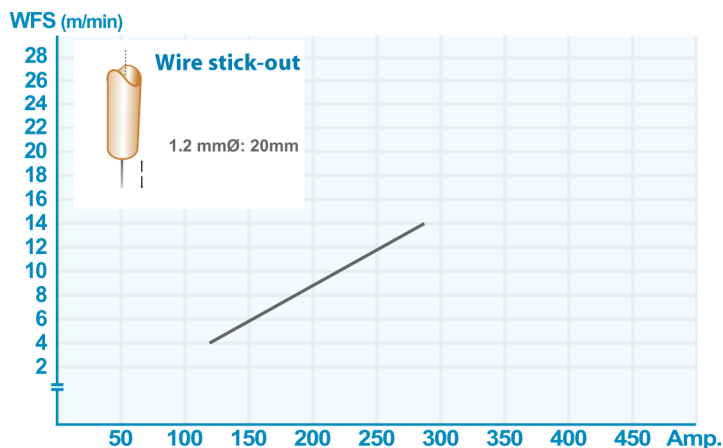
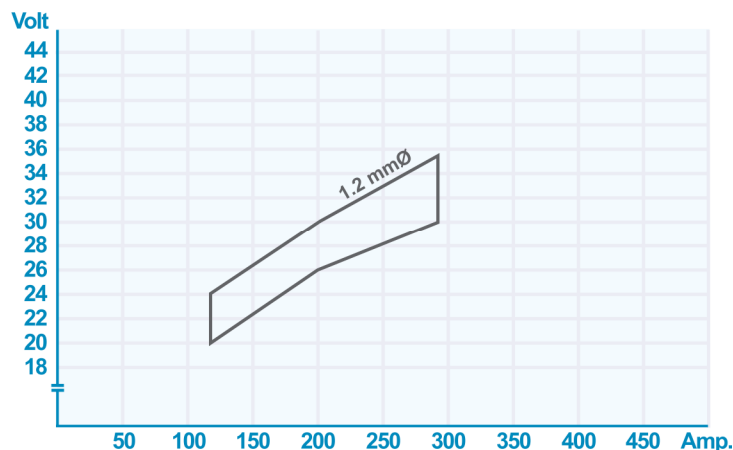
80%Ar - 20%CO₂ / 100%CO₂
 EN ISO 17633-A-T 25 20 R C/M 1
 AWS A5.22 E310T0-1/4
 1.4842

Description and Application

This rutile flux cored wire operates with very stable, spatter free arc producing a bright, smooth weld bead surface and self releasing slag.

PREMIARC™ DW-310 is suitable for welding heat resistant CrNi steels. The service temperature range between +600-900°C should be avoided owing to the risk of embrittlement.

Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.18	0.60	2.10	0.016	0.005	20.4	25.5	-	-	-	-	-	-

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV (J)	°C
	420	620	33	68	0
Guarantee	min.350	min.550	min.20		

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
-	-	-	-	-	-	CWB