

DW-310

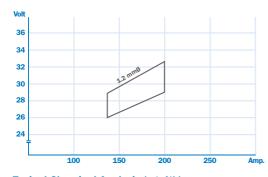
80%Ar - 20%CO₂ / 100%CO₂ EN ISO 17633-A T 25 20 R C1/M21 3 AWS A5.22 E310T0-1/4 EN 1.4842

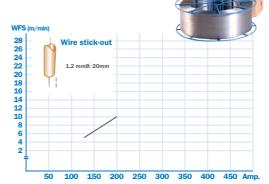
Description and Application

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

DW-310 has a full austenitic micro structure in its weld metal, so it is suited for the welding of heat resistant CrNi steels.

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*

	R₀(MPa)	R _m (MPa)	A ₅ (%)	CA(1)0 _o C
	420	620	33	68
Guaranty	min.350	min.550	min.20	

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



Approvals

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