DW-310 PREMIARC™

Flux cored wire

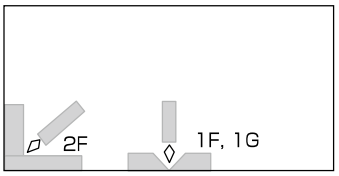
Features: ▪ Suitable for 25%Cr-20%Ni steel

Classification: AWS A5.22 E310T0-1/4

Shielding gas: CO_2 or Ar-CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical (CO_2)	Guaranty [a]
C	0.18	0.20
Si	0.4	1.0
Mn	2.0	1.0~2.5
P	0.02	0.03
S	<0.01	0.03
Ni	20.6	20.0~22.5
Cr	25.3	25.0~28.0
Mo	0.03	0.75
Cu	0.03	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F
1.2	130~220

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	420	-
TS (MPa)	620	552min.
El on 4d (%)	33	30min.
IV 0℃ (J)	68	-

Approvals

CWB	E310T0-1, E310T0-4