

CSF-310

For welding of 25%Cr-20%Ni stainless steel

AWS A5.22 E310T0-4
JIS Z3323 TS310-FB0

Applications

Welding of AISI (SUS) 310S.

Characteristics

- (1) CSF-310 is flux cored wire and designed for Fillet & Horizontal position welding with Ar+20~25%CO₂ gas Shielding.
- (2) It provides the excellent hot crack-resistance.

Notes on usage

- (1) The optimum flow of Ar+20~25%CO₂ for Shielding is 20~25ℓ/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.
- (4) When use hard-surfacing, welding condition keep under 200A/28V.

Typical chemical composition of weld metal (%) (Shielding Gas : 80%Ar+20%CO₂)

C	Mn	Si	P	S	Cr	Ni	Mo
0.10	2.08	0.63	0.019	0.014	25.9	20.1	0.02

Typical mechanical properties of weld metal (Shielding Gas : 80%Ar+20%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)
			0°C
-	583	36.0	70

Size & recommended current range (DC ±)

Dia. mm (in)		1.2 (0.045)
Amp.	F & H-F	140~180