

INERTFIL 310

Drôt pre zváranie TIG/MAG

Welding rod/wire electrode for TIG/MAG-welding process

Pręty/druty do spawania metodami TIG/MAG



Standards:

DIN EN 12072	G 25 20
DIN 8556	SG X 12 Cr Ni 25 20
AWS/ASME SFA-5.9	ER 310
Comparable No. of Materials:	1.4842

SK Vlastnosti a použitie:

Plne austenitický zvärací drôt pre zváranie žiaruvzdorných ocelí s cca. 25 % Cr a 20 % Ni. Určený tiež pre žiaruvzdorné a žiarupevné feritické chrómové ocele, ak sa neočakáva korozívne zafarbenie redukujúcimi spalninami obsahujúcimi síru. Žiaruvzdorný do 1200 °C, húževnatý do -196 °C.

GB Applications and properties:

Fully austenitic welding rod or wire electrode for TIG/MAG-welding of heat resisting steels containing approx. 25% chromium and 20 % nickel. Weld metal exhibits good toughness values down to -196 °C.

POL Zastosowania i własności:

Czysto austenityczne pręty lub druty spawalnicze do spawania TIG/MAG stali żaroodpornych o zawartości ok. 25% chromu i 20% niklu. Stopiwo zachowuje odporność na tworzenie zgorzeli do 1200 °C, również dobrą ciągliwość aż do temperatury -196°C.

Materials for instance:

No. of Materials	EN-Designation	No. of Materials	EN-Designation
1.4840	(G-X 15 CrNi 25 20)	1.4841	(X 15 CrNiSi 25 20)

Rod and wire analysis correspond to all-weld metal analysis (typical values in %)

C	Si	Mn	Cr	Ni	Mo	P	S
0,12	0,60	1,80	26,00	21,00	0,30	≤0,030	≤0,020

Mechanical properties of all-weld metal (single values are typical values):

Heat treatment	0,2 % Proof stress [N/mm ²]	Tensile strength [N/mm ²]	Elongation A ₅ [%]	Impact energy ISO-V [J]
				+20 °C
AW	≥350	≥550	≥30	≥47

AW = as-welded

Analysis and mechanical properties apply to the use of shielding gas:

DIN EN 439 - I1 in TIG – welding
DIN EN 439 - M13 in MAG – welding

Shielding gas acc. to DIN EN 439:

Welding rod for TIG-welding:

I1 (ARCAL 1)

Wire electrode for MAG -welding:

M12 (ARCAL 12), M13 (INARC S 3), M21 (ARCAL 21)

Consumption:

TIG = approx. 10 l/min, MAG = approx. 15 l/min

Form of delivery:

Welding rods				
Dia. [mm]	1,0	2,0	2,4	4,0
Length [mm]	1000			
Approx. Weight of packet [kgs]	10			

Wire electrodes			
Dia [mm]	0,8	1,0	1,2
Wire cage reel K300 [kgs]	15		

Further forms of delivery on request.

Type of current/Polarity/Welding positions:

