

# EZ - MIG 310

## CLASSIFICATION

EN ISO 14343-A	AWS / ASME SFA-5.9	W. Nr.
G 25 20	ER310	1.4842

## DESCRIPTION AND APPLICATION

Austenitic solid wire for GMAW of heat resistant austenitic steels of the 25/20 CrNi types. Weld metal has good oxidation resistance especially at high temperatures due to its high Cr content. Weld metal is heat resistant to temperatures up to 1200°C.

Steel grade	HRN	DIN (W. Nr.)	ASTM / AISI	EN / ISO
High-alloyed heat resistant steels	Č 4578	X15 CrNiSi 25 20 (1.4841)	310 / 314	X15CrNiSi25-21
	-	X12 CrNi 25 21 (1.4845)	310 S	X8CrNi25-21
	-	G-X15 CrNi 25 20 (1.4840)	-	GX15CrNi25-20
	-	X7 CrNi 23 14 (1.4833)	-	X12CrNi23-13
	Č 4586	X20 CrNiSi 25 4 (1.4821)	327	X15CrNiSi25-4
	-	G-X 40 CrNiSi 22 9 (1.4826)	-	GX40CrNiSi22-9
	-	G-X 25 CrNiSi 20 14 (1.4832)	-	GX25CrNiSi20-14
ČL 4577	G-X 40 CrNiSi 25 12 (1.4837)	-	GX40CrNiSi25-12	

## MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R <sub>p0.2</sub> N/mm <sup>2</sup>	R <sub>m</sub> N/mm <sup>2</sup>	A <sub>5</sub> %	KV (+20°C) J
> 350	> 550	> 20	≥ 120

## APPROXIMATE CHEMICAL COMPOSITION OF THE WIRE

	C	Mn	Si	Cr	Ni
%	≤ 0,1	1,7	0,4	25,6	21,0

## SHIELDING GAS

M12 (Ar + 2,5% CO<sub>2</sub>) or M13 (Ar + 1 to 3% O<sub>2</sub>)

## PACKAGING

Wire diameter mm	Winding
0,8; 1,0; 1,2; 1,6	precision-wound (S-S)

12,5 kg - wire spool (wire diameter 0,8 mm)  
15 kg - wire spool (wire diameter 1,0; 1,2 and 1,6 mm)

