

MT-310

1.4842

TIG/MIG welding wire of fully austenitic chrome nickel steel for welding heat resistant steels. Weld metal non – scaling up to +1200°C.

Standard designation

Material No.	1.4842
AWS/ASME SFA-5.9	ER 310
EN 12072	G/W 25 20

Main base metals

Heat-resistant and non-scaling steels, e.g.

1.4832	G-X 25 CrNiSi 20 14	1.4841	X 15 CrNiSi 25 20
1.4837	G-X 40 CrNiSi 25 12	1.4845	X 12 CrNi 25 21
1.4840	G-X 15 CrNi 25 20		

Mechanical properties of all – weld – metal (typical values)

Welding process			TIG I1	MIG M11
Gas shield			untreated	untreated
Thermal treatment			+20°	+20°C
Test temperature		[°C]		
0.2%-yield strength	R _{p0.2}	MPa	315	315
Tensile strength	R _m	MPa	490	490
Elongation	A ₅	[%]	25	25
Impact strength	A _v	[J]	80	80

Average chemical composition of all - weld – metal (%)

C	Si	Mn	Cr	Ni
0,12	0,5	1,0-2,50	25,0-28,0	20,0-22,5

Structure

Fully austenitic

Gas types applicable TIG

I1

Gas types applicable MIG

M 11, M 21, M 23 and M 32

TIG rod diameters, unit weights

Diameter [mm]	Length [mm]	Kg per box
1,00	1000	10,0
1,60	1000	10,0
2,00	1000	10,0
2,40	1000	10,0
3,20	1000	10,0
4,00	1000	10,0
5,00	1000	10,0

MIG welding wires

Diameter 0,8mm 1,0mm 1,2mm 1,6mm

Welding positions MIG acc.to EN ISO 6947

PA, PB, PF

Welding positions TIG acc.to EN ISO 6947

PA, PB, PC, PF, PE

Current/Polarity TIG

= -

Current/Polarity MIG

= +