

## 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 <sub>p0,2</sub>	MPa	315	315
Tensile strength	R <sub>m</sub>	MPa	490	490
Elongation	A <sub>5</sub>	[%]	25	25
Impact strength	A <sub>v</sub>	[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 Gas types applicable MIG

I1  
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

= +