

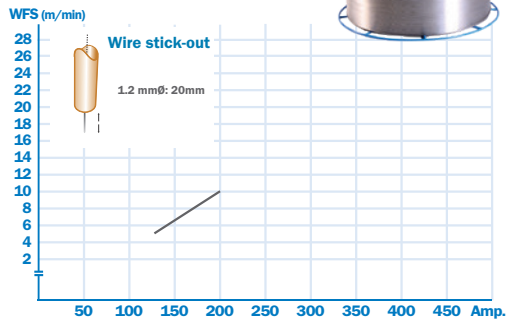
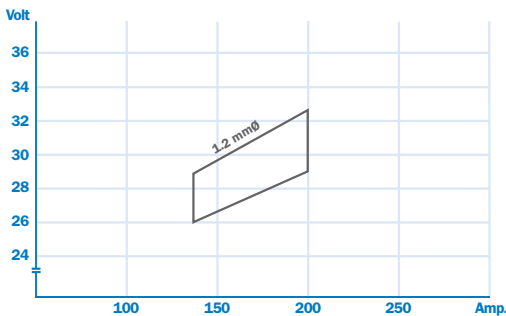
## Description and Application

This rutile flux cored wire operates with a very stable, spatter free arc producing a bright, smooth weld bead surface and self releasing slag.

**DW-310** has a full austenitic micro structure in its weld metal, so it is suited for the welding of heat resistant CrNi steels.



### Recommended Parameter Range, for flat position\*



### Typical Chemical Analysis (wt. %)\*

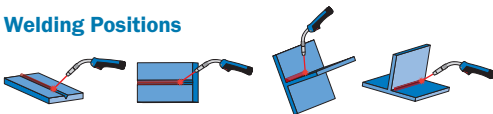
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.18	0.60	2.10	0.016	0.005	20.4	25.5	-	-	-	-	-	-

### Typical Mechanical Properties\*

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)0°C
Guaranty	min.350	min.550	min.20	68

\* The above values and parameters are for all weld metal produced using Ar+CO<sub>2</sub> shielding gas

### Welding Positions



### Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	CE