

Flux Cored Wire for Stainless Steel

KFW-310

Classification

AWS	E310T1-1/4	—
JIS	Z3323	TS310-FB0
EN	17633-A	T 25 20 P C 1
GB	T 17853	E310T1-1

Shielding Gas: CO₂ or Ar+20%CO₂

Applications and Features

- (1) Weld deposit is 19.5% Cr-10% Ni, which is suitable for welding 18% Cr-8% Ni stainless steel (AISI 301、302、304、305、308).
- (2) It provides excellent weldability and crack resistance due to proper ferrite contents in the weld metal.
- (3) Stable arc, good slag removal, and easy control of weld puddle, low spatters, X-ray quality welds and good penetration.

Welding Instruction

- (1) Use Ar blend with 1~2%O₂ for high current, spray transfer welding.
- (2) Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding.
- (3) For other instructions, please refer to Appendix D.
- (4) For extra information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : CO₂)

C	Si	Mn	P	S	Cr	Ni
0.11	0.41	1.90	0.01	0.01	27.3	21.54

Typical Mechanical Properties of Weld Metal (Shielding Gas : CO₂)

Tensile Strength N/mm ² (kgf/mm ²)	Elongation %
610	40

Size and Suggested Operating Range (DC+)

Diameter (mm)	F/H-fillet		V/OH	
	Amp	Volt	Amp	Volt
1.2	100~300	20~36	100~200	24~30
1.6	200~360	26~40	—	—