

80%Ar - 20%CO₂ / 100%CO₂
 EN ISO 17633-A-T 25 20 R C/M 1
 AWS A5.22 E310T0-1/4
 1.4842

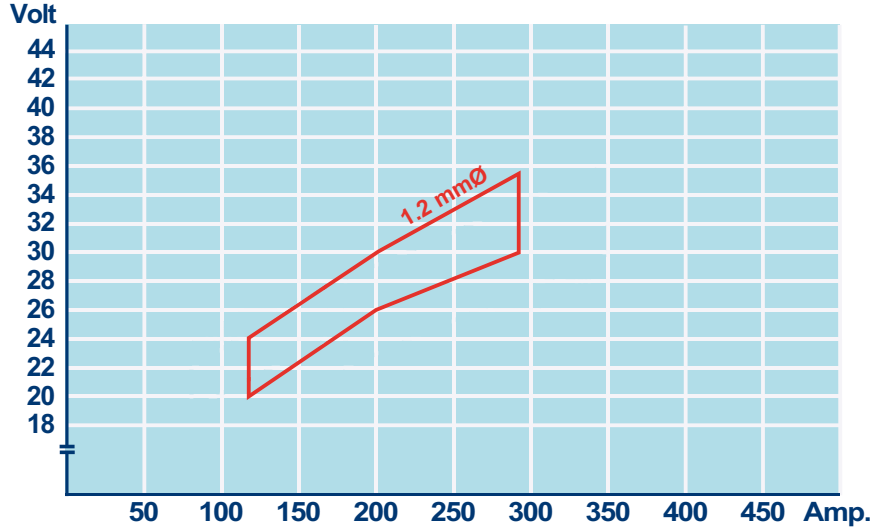
80%Ar - 20%CO₂
 EN ISO 17633-A-T 29 9 R M 3
 AWS A5.22 E312T0-4
 1.4337

Description and Application

These are rutile flux cored wires which operate with very stable, spatter free arcs producing a bright, smooth weld bead surfaces and self releasing slag.

DW-310 is suitable for welding heat resistant CrNi steels. The service temperature range between +600-900°C should be avoided owing to the risk of embrittlement. DW-312 is designed for welding dissimilar materials of which one component is high in carbon or in nickel. Due to a two-phase weld deposit this wire has a high resistance to weld cracks and fissures, even with considerable dilution by austenite-forming elements such as nickel and carbon. DW-312 is also used for applying the first layer prior to overlaying with hard facing materials.

Recommended Parameter Range, for flat position



Note: The above parameters are typical range for DW-310 with mixed gas. Adjust voltage for 100% CO₂.

Chemical Analysis

	C	Si	Mn	P	S	Ni	Cr	Mo	N	Cu	FS	FN	FNW
DW-310	0.18	0.60	2.10	0.016	0.005	20.4	25.5	-	-	-	-	-	-
DW-312	0.12	0.60	1.20	0.018	0.006	10.2	28.4	-	-	-	60	>18.0	50.7

Mechanical Properties

	R _e (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	CV (J)	°C
DW-310	420	620	33	68	0
DW-312	580	740	23	-	-

Welding Positions

DW-310
1.2mm



DW-312
1.2mm



Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
DW-310	-	-	-	-	-	-	CWB
DW-312	-	-	-	-	-	-	CWB