







CEWELD AA 312

TYPE	Rutile fluxcored welding wire developed for welding dissimilar steels with difficult weldability. (Type 29 9, 312, 1.4337)						
APPLICATIONS	Buffer layers before hardfacing, armor plate, exhaust systems, high, Manganese austenitic steel, heterogeneous welding, difficult to weld and unknown steels.Stainless steel, C45, C60, Manganese steel, Spring steel, Buffer layers! 25CrMo4, 42CrMo4, 50CrMo4, 42MnV7, 1.7218, 1.7225, 1.7228, 1.5223, AISI 4130, 4140, 4150 hss, high speed steel, stainless steel, cast steel, unknown steel, difficult to Weld steel, cock wheels,						
PROPERTIES	Very good welding characteristics and not sensitive for cracks and fissures. High tensile strength with good corrosion and acid resistance. Scale resistance up to 1150°C, crack and wear resistant, suitable for rebuilding wornout parts. Excellent corrosion resistance against high temperature liquid acids. Much better welding characteristics than solid wire.						
CLASSIFICATION	AWS	A 5.22: E312T0-4					
	EN ISO	17633-A: T 29 9 R M21 3					
	F-nr	6					
	FM	5					
	W.Nr.	1.4337					
SUITABLE FOR	ISO 15608: 11 (0,25 % < C ≤ 0,85 %) Type: 29% Cr, 9%Ni 1.3401, 1.4006, 1.4339, 1.4340, 1.4347, 1.4460 X120Mn12, X10Cr13, GX32CrNi28-10, GX49CrNi27-4, GX8CrCrNiN26-7, X3CrNiMoN27-5-2 UNS S41000 AISI 329, 410. S235, E295 Hss, C45, C60, dissimilar welding, maintenance, buffer layers, repairing cock wheels, 42MnV7, 25CrMo4, 42CrMo4, 50CrMo4, 1.5223, 1.7218, 1.7225, 1.7228, Armox, Hardox						
APPROVALS	CE						
WELDING POSITIONS	<div>   </div>						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	Cr	Ni	S
	0.12	0.6	1.2	0.025	29.5	9.5	0.015
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)			
	As Welded /	580	740	24			
REDRYING TEMPERATURE	140°C / 24 hr						
GAS ACCORDING EN 14175	M21						



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AA 312 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663417374