





TYPE Rutile fluxcored welding wire developed for welding dissimilar steels with difficult weldabillity.

(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



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

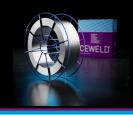
С	Sı	Mn	P	Cr	Nı	S
0.12	0.6	1.2	0.025	29.5	9.5	0.015

ALL WELD MECHANICAL PROPERTIES

Heat	R <sub>P0,2</sub>	Rm	A5	
Treatment	MPa	MPa	(%)	
As Welded /	580	740	24	

REDRYING TEMPERATURE 140°C / 24 hr

GAS ACCORDING EN 14175 M21







AA 312 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663417374