CEWELD AA 312

certilas® THE FILLER METAL SPECIALIST

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: 8 >19% Cr Type: 29% Cr, 9%Ni
1.3401, 1.4006, 1.4339, 1.4340, 1.4347, 1.4460, 1.4762, 1.4085
X120Mn12, X10Cr13, GX32CrNi28-10, GX49CrNi27-4, GX8CrCrNiN26-7, X3CrNiMoN27-5-2, X 10 CrAl 24, G-X 70 Cr 29
UNS S41000
AISI 329, 410. S235, E295
Hss, C45, C60, dissimilar welding S335 - X120Mn12, 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 (%)

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	Rm MPa	A5 (%)
As Welded /	580	740	24

REDRYING TEMPERATURE

140°C / 24 hr

GAS ACCORDING EN 14175

M21

CEWELD AA 312

AA 312 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663417374