






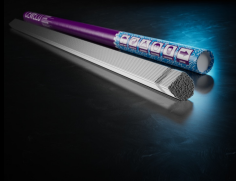




CEWELD 312 Tig

TYPE	Solid stainless steel welding wire for Tig welding. (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. Is suitable for wear resisting build-ups on clutches, gear wheels, shafts, etc. It is also suitable for repair welding of tools. For welding of unalloyed steels with limited weldability and low-alloyed steels of higher strength. Used as stress-relieved buffer layer when cladding cold and warm machine tools. For joining of high manganese and CrNiMn-steels and combinations of steels of different chemical composition or strength.						
PROPERTIES	Scale resistance up to 1150°C, crack and wear resistant, suitable for rebuilding wornout parts. Excelent corrosion resistance against high temperature liquid acids. Application temperature max. 300°C. High resistance to hot cracking, good toughness and strength properties. The weld metal also work hardens.						
CLASSIFICATION	AWS	A 5.9: ER312					
	EN ISO	14343-A: W 29 9					
	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 THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni
	0.012	0.5	1.8	0.015	0.015	29	9.5
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	Hardness Brinell Hardness	
	As Welded /	640	800	23	50	Avg. 240	
REDRYING TEMPERATURE	Not required						
GAS ACCORDING EN 14175	I1						



CEWELD 312 Tig

312 TIG 1,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663417381

312 TIG 1,2 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663417398

312 TIG 1,6 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663417404

312 TIG 2,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663417411

312 TIG 2,4 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663417428

312 TIG 3,2 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663417435