CEWELD 312 Tig

certilas® THE FILLER METAL SPECIALIST

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

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	Rm MPa	A5 (%)	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

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	Type	KG/unit	EANCode
312 TIG 1,0 X 1000MM	Tube	5	8720663417381
312 TIG 1,2 X 1000MM	Tube	5	8720663417398
312 TIG 1,6 X 1000MM	Tube	5	8720663417404
312 TIG 2,0 X 1000MM	Tube	5	8720663417411
312 TIG 2,4 X 1000MM	Tube	5	8720663417428
312 TIG 3,2 X 1000MM	Tube	5	8720663417435