CEWELD 312 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid stainless steel welding wire for Tig welding. (Type 29 9, 312, 1.4337)

APPLICATIONS

CEWELD® 312 Tig was developed for welding buffer layers prior to build-up welding of armor plates, exhaust systems, high-manganese austenitic steel, and for heterogeneous welding of difficult-to-weld and unknown steels. Another application is the production of tough joints (one layer) of unalloyed or low-alloy, higher-strength structural steels to manganese hard steel and CrNiMn steels. It is also suitable for build-ups on couplings, gears, shafts, etc., as well as for repairing tools. Max. operating temperature: 300 °C

PROPERTIES

CEWELD® 312 Tig has a scale resistance of up to 1150°C, is crack and wear resistant, and is suitable for rebuilding worn parts. CEWELD® 312 Tig has a low tendency to hot cracking and good toughness and strength properties. In addition, the weld metal is cold worked.

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: 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 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	Impact Energy (J) ISO-V -196°C	Hardness Brinell Hardness
As Welded /	525	710	25	80	50	Avg. 240

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

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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