

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: 8 >19% Cr Type: 29% Cr, 9%Ni**
 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 (%)

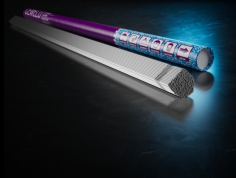
C	Si	Mn	P	S	Cr	Ni
0.012	0.5	1.8	0.015	0.015	29	9.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		Hardness Brinell Hardness
				RT	-196°C	
As Welded /	525	710	25	80	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