



# CEWELD 312

TYPE	Solid stainless steel welding wire for dissimilar welding. (Type 29 9, 312, 1.4337)																			
APPLICATIONS	CEWELD® 312 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 has a scale resistance of up to 1150°C, is crack and wear resistant, and is suitable for rebuilding worn parts. CEWELD® 312 has a low tendency to hot cracking and good toughness and strength properties. In addition, the weld metal is cold worked.																			
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER312</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 29 9</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4337</td> </tr> </table>	AWS	A 5.9: ER312	EN ISO	14343-A: G 29 9	F-nr	6	FM	5	W.Nr.	1.4337									
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SUITABLE FOR	<p><b>ISO 15608: 8 &gt;19% Cr Type: 29% Cr, 9%Ni</b>            1.3401, 1.4006, 1.4339, 1.4340, 1.4347, 1.4460, 1.4762, 1.4085            X120Mn12, X10Cr13, GX32CrNi28-10, GX49CrNi27-4, GX8CrCrNi26-7, 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</p>																			
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WELDING POSITIONS																				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>FNW</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.5</td> <td>1.8</td> <td>30</td> <td>9</td> <td>79</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	FNW	0.1	0.5	1.8	30	9	79							
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REDRYING TEMPERATURE	Not required																			
GAS ACCORDING EN 14175	I1, M11, M13, M14, M12																			



# CEWELD 312

312 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663417343

312 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663417350

312 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663417367