



CEWELD 312

TYPE	Solid stainless steel welding wire for dissimilar 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. 1.3401 X120Mn12, 1.4006 X10Cr13, 1.4339 GX32CrNi28-10, 1.4340 GX49CrNi27-4, 1.4347 GX8CrCrNiN26-7, 1.4460 X3CrNiMoN27-5-2 UNS S41000, AISI 329, 410, S235, E295																			
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	<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									
AWS	A 5.9: ER312																			
EN ISO	14343-A: G 29 9																			
F-nr	6																			
FM	5																			
W.Nr.	1.4337																			
SUITABLE FOR	<p>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, Armax, Hardox</p>																			
APPROVALS	CE																			
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							
C	Si	Mn	Cr	Ni	FNW															
0.1	0.5	1.8	30	9	79															
ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th>R_{P0,2}</th> <th>R_m</th> <th>A₅</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness Brinell Hardness</th> </tr> <tr> <th>MPa</th> <th>MPa</th> <th>(%)</th> <th>RT</th> <th>-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>515</td> <td>700</td> <td>25</td> <td>100</td> <td>60</td> <td>Avg. 240</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2}	R _m	A ₅	Impact Energy (J) ISO-V		Hardness Brinell Hardness	MPa	MPa	(%)	RT	-196°C	As Welded /	515	700	25	100	60	Avg. 240
Heat Treatment	R _{P0,2}		R _m	A ₅	Impact Energy (J) ISO-V		Hardness Brinell Hardness													
	MPa	MPa	(%)	RT	-196°C															
As Welded /	515	700	25	100	60	Avg. 240														
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