



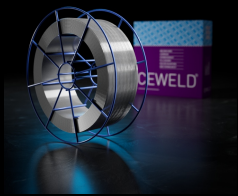


CEWELD 312

| | | | | | | | |
|---|--|--------------------------|-----------------------|-----------------------|---|-----|------------------------------|
| 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 | AWS | A 5.9: ER312 | | | | | |
| | EN ISO | 14343-A: G 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, Armax, Hardox | | | | | | |
| APPROVALS | CE | | | | | | |
| WELDING POSITIONS | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C | Si | Mn | Cr | Ni | FNW | |
| | 0.1 | 0.5 | 1.8 | 30 | 9 | 79 | |
| ALL WELD MECHANICAL PROPERTIES | Heat Treatment | R _{P0,2} MPa | R _m MPa | A ₅ (%) | Impact Energy (J) ISO-V RT -196°C | | Hardness Brinell Hardness |
| | 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 |