

INOX R312

Electrodes MMA [SMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 3581-A : E 29 9 R 12 DIN 8556 : E 29 9 R26 AWS A-5.4 : E 312-17 W.Nr. : 1.4337		Hardfacing and repairing Metallurgy (Steelworks) Mining

- Electrode for welding austenitic-ferritic steels with approx. 40% ferrite in the deposit.
- High resistance to stress corrosion cracking.
- Very good resistance to hot cracking.
- It is recommended for hybrid connections (dissimilar joints) with difficult-to-weld steels and stainless steels with high-carbon steels.
- It is used for welding difficult-to-weld steels, e.g. hardenable, high-carbon tool steels, die and spring steels (e.g. springs).

Application

Hardfacing of metal parts cooperating with each other and exposed to abrasion. For high temperature tools and furnace parts. Hardfacing of rails, dies and tools for hot forming. Making welds on difficult-to-weld materials with high carbon content and ingredients that increase hardenability. Reconstruction of mechanical elements, including racks, piston rods, etc., reconstruction of dies, buffer layer for cutting blades.

Base material

DIN	W.Nr.	AISI/ASME	PN
X10 CrAl24	1.4762	446	H24JS
G-X70 Cr29	1.4085		
G-X32 CrNi28 10	1.4339		
G-X40 CrNi27 4	1.4340		
G-X8 CrNi26 7	1.4347		
X2 CrTi12	1.4512	409	
X5 CrNi18 9	1.4301	304	0H18N9
25CrMo4	1.7218	4130	20HM, 25HM
42CrMo4	1.7225	4145	40HM
50CrMo4	1.7228	5150	50H
42MnV7	1.5223		
34CrNiMo6	1.6582		34HNM
41CrMo4	1.7223	4140	
C45	1.0503	M1044	C45
C60	1.0601	1060	C60
C55	1.0535	1055	C55
Hard-weldable steels			
Austenitic manganese steels			
High-strength steels			
Tool steels			
High carbon steels			
High-alloy steels			

Typical chemical composition %

C	Si	Mn	Cr	Ni
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0,11 0,90 0,90 29,00 9,00

Typical mechanical properties

Yield strength Re [N/mm2]	>450
Tensile strength Rm [N/mm2]	>650
Elongation A5 [%]	>15
Hardness	app. 235 HB (depends on welding conditions and chemical composition of the base material) /
Coating type	rutile
Ferrite content	FN = app. 40
Welding current	
Welding positions	
Redrying	300 - 350°C / 2 h

Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	300 /	55-85	1,4	8,4	61
3,2	350 /	80-120	1,5	9,0	30
4,0	350 /	110-150	1,5	9,0	20
5,0	350 /	160-210	1,5	9,0	14

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