CEWELD 312 Tig

certilas® THE FILLER METAL SPECIALIST

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
W.Nr.	1.4337
F-nr	6
FM	5

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

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	525	710	25	80	50	240 HB

REDRYING

Not required

GAS ACC. EN ISO 14175

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312 TIG 1,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417381

312 TIG 1,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417398

312 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417404

312 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417411

312 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417428

312 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417435