



SUPERINOX 312

STAINLESS STEEL (Dissimilar Steel Welding)

AWS A/SFA 5.4 **E312-16**

CLASSIFICATION:

ISO 3581-A
E 29 9 R 12

IS 5206
E 29.9 R26

KEY FEATURES:

- Rutile type medium heavy coating
- 30/10 type SS deposit
- High strength weld with excellent resistance to cracking, fissuring and oxidation
- Two phase structure with high ferrite
- Quiet and stable arc
- Low spatter, Smooth weld bead
- Easy slag detachability
- All position welding capability
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding difficult to weld steels ex. high C hardenable tool, die and spring steels, 13% Mn steels, free cutting steels, high temperature steels, cast steels
- Repair of worn out parts and underlay before hardfacing
- Dissimilar joints between stainless and high carbon steels and unknown steels
- Suitable for problematic steels with higher strength such as pressing dies, trimming tools, armor plates


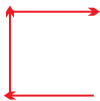
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni
0.07	0.9	0.95	29.5	8.7

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	760	29
Specification		660 min	22 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
1.6 X 250	30-45	 AC (70 OCV) /DCEP All Positions, except vertical Down  REDRYING CONDITION: 250-300°C for minimum 1 hr.
2.0 x 300	50-80	
2.5 x 350	80-100	
3.2 x 350	110-140	
4.0 x 350	150-180	

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.

EQUIVALENT:

GMAW	GTAW
Miginox 312	Tiginox 312