



CEWELD 312

TYPE Solid stainless steel welding wire for dissimilar welding

TOEPASSINGEN Buffer layers before hardfacing, armor plate, exhaust systems, high, Manganese austenitic steel, heterogeneous welding, difficult to weld and unknown steels.

EIGENSCHAPPEN Scale resistance up to 1150°C, crack and wear resistant, suitable for rebuilding wornout parts. Excelent corrosion resistance against high temperature liquid acids.

CLASSIFICATIE

AWS	A 5.9: ER312
EN ISO	14343-A: G 29 9
W.Nr.	1.4337
F-nr	6
FM	5

GESCHIKT VOOR **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

GOEDKEURINGEN CE

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	FNW
0.1	0.5	1.8	30	9	79

MECHANISCHE WAARDEN

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	515	700	25	100	60	240 HB

HERDROGEN Not required

GAS ACC. EN ISO 14175 I1, M11, M13, M14



CEWELD 312

312 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417343

312 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417350

312 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417367