CEWELD AA 312

certilas® THE FILLER METAL SPECIALIST

TYPE	Rutile fluxcored welding wire developed for welding dissimilar steels with difficult weldabillity
APPLICATIONS	Buffer layers before hardfacing, armor plate, exhaust systems, high, Manganese austenitic steel, heterogeneous welding, difficult to weld and unknown steels.
PROPRIÉTÉS	Very good welding characteristics and not sensitive for cracks and fissures. High tensile strength with good corrosion and acid resistance. Scale resistance up to 1150°C, crack and wear resistant, suitable for rebuilding wornout parts. Excellent corrosion resistance against high temperature liquid acids. Much better welding characteristics than solid wire.

CLASSIFICATION

AWS	A 5.22: E312T0-4
EN ISO	17633-A: T 29 9 R M21 3
W.Nr.	1.4337
F-nr	6
FM	5

CONVIENT POUR

ISO 15608: 8 >19% Cr Type: 29% Cr, 9%Ni
1.3401, 1.4006, 1.4339, 1.4340, 1.4347, 1.4460, 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

AGRÉMENTS: CE

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

C	Si	Mn	P	Cr	Ni	S
0.12	0.6	1.2	0.025	29.5	9.5	0.015

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	580	740	24	HRc

ETUVAGE: 140°C / 24 hr

GAS ACC. EN ISO 14175: M21

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AA 312 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417374