



CEWELD 312 Tig

TYPE	Solid stainless steel welding wire for Tig welding. (Type 29 9, 312, 1.4337)																						
APPLICATIONS	CEWELD® 312 Tig was developed for welding buffer layers prior to build-up welding of armor plates, exhaust systems, high-manganese austenitic steel, and for heterogeneous welding of difficult-to-weld and unknown steels. Another application is the production of tough joints (one layer) of unalloyed or low-alloy, higher-strength structural steels to manganese hard steel and CrNiMn steels. It is also suitable for build-ups on couplings, gears, shafts, etc., as well as for repairing tools. Max. operating temperature: 300 °C																						
PROPERTIES	CEWELD® 312 Tig has a scale resistance of up to 1150°C, is crack and wear resistant, and is suitable for rebuilding worn parts. CEWELD® 312 Tig has a low tendency to hot cracking and good toughness and strength properties. In addition, the weld metal is cold worked.																						
CLASSIFICATION	<table><tr><td>AWS</td><td>A 5.9: ER312</td></tr><tr><td>EN ISO</td><td>14343-A: W 29 9</td></tr><tr><td>W.Nr.</td><td>1.4337</td></tr><tr><td>F-nr</td><td>6</td></tr><tr><td>FM</td><td>5</td></tr></table>							AWS	A 5.9: ER312	EN ISO	14343-A: W 29 9	W.Nr.	1.4337	F-nr	6	FM	5						
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EN ISO	14343-A: W 29 9																						
W.Nr.	1.4337																						
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SUITABLE FOR	<p>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, Armax, Hardox</p>																						
APPROVALS	CE																						
WELDING POSITIONS																							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td><td>P</td><td>S</td><td>Cr</td><td>Ni</td></tr><tr><td>0.012</td><td>0.5</td><td>1.8</td><td>0.015</td><td>0.015</td><td>29</td><td>9.5</td></tr></table>							C	Si	Mn	P	S	Cr	Ni	0.012	0.5	1.8	0.015	0.015	29	9.5		
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MECHANICAL PROPERTIES	<table><thead><tr><th rowspan="2">Heat Treatment</th><th rowspan="2">R_{P0,2} (MPa)</th><th rowspan="2">Rm (MPa)</th><th rowspan="2">A5 (%)</th><th colspan="2">Impact Energy (J) ISO-V</th><th rowspan="2">Hardness</th></tr><tr><th>RT</th><th>-196°C</th></tr></thead><tbody><tr><td>As Welded</td><td>525</td><td>710</td><td>25</td><td>80</td><td>50</td><td>240 HB</td></tr></tbody></table>							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
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REDRYING	Not required																						
GAS ACC. EN ISO 14175	I1																						



CEWELD 312 Tig

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