



CEWELD 312

TYPE	Solid stainless steel welding wire for dissimilar welding. (Type 29 9, 312, 1.4337)																					
APPLICATIONS	CEWELD® 312 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 has a scale resistance of up to 1150°C, is crack and wear resistant, and is suitable for rebuilding worn parts. CEWELD® 312 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: G 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: G 29 9	W.Nr.	1.4337	F-nr	6	FM	5						
AWS	A 5.9: ER312																					
EN ISO	14343-A: G 29 9																					
W.Nr.	1.4337																					
F-nr	6																					
FM	5																					
SUITABLE FOR	<p>ISO 15608: 8 >19% Cr Type: 29% Cr, 9%Ni</p> <p>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><thead><tr><th>C</th><th>Si</th><th>Mn</th><th>Cr</th><th>Ni</th><th>FNW</th></tr></thead><tbody><tr><td>0.1</td><td>0.5</td><td>1.8</td><td>30</td><td>9</td><td>79</td></tr></tbody></table>						C	Si	Mn	Cr	Ni	FNW	0.1	0.5	1.8	30	9	79				
C	Si	Mn	Cr	Ni	FNW																	
0.1	0.5	1.8	30	9	79																	
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>515</td><td>700</td><td>25</td><td>100</td><td>60</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	515	700	25	100	60	240 HB
Heat Treatment	R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness																
				RT	-196°C																	
As Welded	515	700	25	100	60	240 HB																
REDRYING	Not required																					
GAS ACC. EN ISO 14175	I1, M11, M13, M14, M12																					



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