







# 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	AWS	A 5.9: ER312					
	EN ISO	14343-A: G 29 9					
	W.Nr.	1.4337					
	F-nr	6					
	FM	5					
SUITABLE FOR	<b>ISO 15608: 8 &gt;19% Cr Type: 29% Cr, 9%Ni</b> 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						
APPROVALS	CE						
WELDING POSITIONS	<div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div>						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	FNW	
	0.1	0.5	1.8	30	9	79	
MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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