



CEWELD AA 312

TYPE Rutile fluxcored welding wire developed for welding dissimilar steels with difficult weldability

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

EIGENSCHAFTEN 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.

KLASSIFIKATION

| | |
|--------|-------------------------|
| 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 |

GEEIGNET FÜR **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

ZULASSUNGEN CE

SCHWEISSPOSITIONEN

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

MECHANISCHE GÜTEWERTE

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded | 580 | 740 | 24 | HRc |

RÜCKTROCKNUNG 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 |