

CEWELD 312



TYPE Solid stainless steel welding wire for dissimilar welding. (Type 29 9, 312, 1.4337)

APPLICATIONS Buffer layers before hardfacing, armor plate, exhaust systems, high, Manganese austenitic steel,

heterogeneous welding, difficult to weld and unknown steels. Is suitable for wear resisting buildups on clutches, gear wheels, shafts, etc. It is also suitable for repair welding of tools. For welding of unalloyed steels with limited weldability and low-alloyed steels of higher strength. Used as stressrelieved buffer layer when cladding cold and warm machine tools. For joining of high manganese and CrNiMn-steels and combinations of steels of different chemical composition or strength. 1.3401 X120Mn12, 1.4006 X10Cr13, 1.4339 GX32CrNi28-10, 1.4340 GX49CrNi27-4, 1.4347 GX8CrCrNiN26-

7, 1.4460 X3CrNiMoN27-5-2 UNS S41000, AISI 329, 410, S235, E295

PROPERTIES Scale resistance up to 1150°C, crack and wear resistant, suitable for rebuilding wornout parts.

> Excelent corrosion resistance against high temperature liquid acids. Application temperature max. 300°C. High resistance to hot cracking, good toughness and strength properties. The weld metal

also work hardens.

CLASSIFICATION **AWS** A 5.9: ER312

EN ISO 14343-A: G 29 9

W.Nr. 1.4337 F-nr 6 FΜ 5

SUITABLE FOR 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

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER

METAL (%)

0.1 0.5 1.0 20 0 70	C	Si	Mn	Cr	Ni	FNW
0.1 0.5 1.6 30 9 79	0.1	0.5	1.8	30	9	79

MECHANICAL PROPERTIES

Heat	t R _{P0,2} Rm A		A5	Impa	ct Energy (J) ISO-V	
Treatment	(MPa)	(MPa)	(%)	RT	-196°C	Hardness
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	