

# CEWELD AA 312

**TYPE** Rutile fluxcored welding wire developed for welding dissimilar steels with difficult weldability. (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. Stainless steel, C45, C60, Manganese steel, Spring steel, Buffer layers! 25CrMo4, 42CrMo4, 50CrMo4, 42MnV7, 1.7218, 1.7225, 1.7228, 1.5223, AISI 4130, 4140, 4150 hss, high speed steel, stainless steel, cast steel, unknown steel, difficult to Weld steel, cock wheels,

**PROPERTIES** 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.

**CLASSIFICATION**

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

**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 WELD METAL (%)**

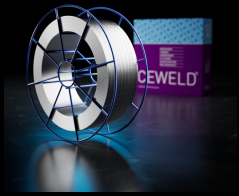
C	Si	Mn	P	Cr	Ni	S
0.12	0.6	1.2	0.025	29.5	9.5	0.015

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	580	740	24	HRc

**REDRYING** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21



# CEWELD AA 312

AA 312 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417374