

AA 312

CATEGORY FCAW Flux-Cored

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

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

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: E 312 T0-1 A 5.22: E 312 T0-4
EN ISO	T 29/9 RM3 (C3)
DIN: W.Nr.	1.4337
DIN	8556: 29 9

SUITABLE FOR 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,

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	FNW
0.12	1.20	0.60	29.5	9.5	50.7

MECHANICAL PROPERTIES

Heat treatment	RP0,2 (N/mm2)	Rm (N/mm2)	A5 (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				-20C	-40°C	-60C	
AW with M21	580	740	24				

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2			K-300	15	1080
1.6			K-300	15	1080

REDRYING TEMPERATURE 150°C/24hr

GAS ACC. EN ISO 14175: M21