

SP 312

CATEGORY Metal spray wires

TYPE Solid high Cr/Ni metal spray wire

APPLICATIONS Ceweld SP 312 is a Chromium- Nickel alloy for use at operating temperatures up to 1020°C. It contains a high chromium content for good corrosion resistance and remarkable strength properties, especially under conditions of frequent switching or wide temperature fluctuations. Used for heating elements in domestic appliances and industrial equipment. Ceweld SP 312 can be applied with the flame spray process and the electric arc process as well.

PROPERTIES Excellent corrosion resistance against many media and acid environments. Good thermal shock resistance.

CLASSIFICATION

AWS	A 5.9: ER 312
EN ISO	14343-A: G 29 9
DIN: W.Nr.	1.4337

SUITABLE FOR Ceweld SP 312 is a Chromium- Nickel metal spray alloy for use at operating temperatures up to 1020°C. It contains a high chromium content for good corrosion resistance and remarkable strength properties, especially under conditions of frequent switching or wide temperature fluctuations. Used for heating elements in domestic appliances and industrial equipment.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
< 0.15	28.0-32.0	8.0-10.5	<0.75	1.0-2.5	0.30-0.65	<0.03	<0.03	<0.75

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V (J)	Hardness HB
as sprayed					200-220

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.6			K-300 / D-300	15	
3.17			K-415 / H-420	25	

REDRYING TEMPERATURE not required