



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 _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	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