ROWELD- 312

A HIGH ALLOY "UNIVERSAL" ELECTRODE FOR JOINING STEELS OF UNKNOWN COMPOSITION

BASIC ALLOY: C, MN, CR, NI
AWS/SFA-5.4: E312-16
EN ISO 3581-A E 29 9 R 32

KEY FEATURES:

It is an electrodes gives 30/10 deposit, it has two phase structure with high nos. of ferrites in austenitic matrix. It is suitable for carbon steel, low alloy steel, dissimilar materials etc. electrode is recommended also for unknown steel, leaf springs and difficult-to-weld with higher strength

APPLICATIONS

- It is ideally suitable for welding difficult-to-weld e.g. high hardenable tool, die & sparing steel, 13% Mn steels, free cutting steels, high temperature steels..
- Dissimilar joints between stainless steel and high carbon steels.
- Surfacing to metal to metal wear areas, hot working tools, furnace components etc.
- Suitable rebuilding chemical agitator blades, shafts, rolling mill spindles, bucket lips

RE-DRY CONDITION:

- Re-Dry the electrode at 250°Cfor one hour before use.

CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Cr	Ni
0.15 max.	0.50-2.50	1.00 Ma	0.030 Max	0.040 Max	28.00-32.00	8.00-10.50

MECHANICAL PROPERTIES:

UTS (N/mm)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @	Hardness	FERRITE (FN)
660-850	22-28	+20C : 30-60 J	220 BHN	40 FN

WELDING POSITION

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/ AC) Amps	Kg/pkt.	Kg/Case
2.50/ 2.40	3/ 32"	50-80	2	10
3.15/ 3.20	1/ 8"	75-100	2	10
4.00	5/ 32"	110-140	2	10
5.00	3/ 16"	150-180	2	10