

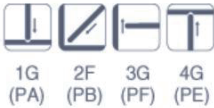
E312-16

AWS A5.4 E312-16
DIN 8556 E29 9 R 26

Description:

A lime-titania type electrode which contains 29%Cr-9%Ni, As the weld metal has high ferrite structure, its anti-crack performance is excellent. It is used for welding of dissimilar metals and underlaying welding of hard surfacing.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	750
Yield strength(MPa):	--
Elongation(%):	24

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0,09	1,59	0,02	0,003	0,66	9,49	28,8	--	--

Welding Current:(AC/DC±)

Diameter(mm)		2,5	3,2	4,0	5,0
Current/A	F/H	60-80	80-120	100-150	140-180
Current/A	V/OH	40-70	60-100	80-130	-

Note:

- 1.The electrodes should be baked 1 hours in 300-350°C before using.
- 2.Welding in short arc,and swing scope should not excess 2.5 times of the electrode diameter.