



CEWELD AA 312

TYPE	Rutile fluxcored welding wire developed for welding dissimilar steels with difficult weldability						
ANWENDUNGEN	Buffer layers before hardfacing, armor plate, exhaust systems, high, Manganese austenitic steel, heterogeneous welding, difficult to weld and unknown steels.						
EIGENSCHAFTEN	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.						
KLASSIFIKATION	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					
GEEIGNET FÜR	ISO 15608: 8 >19% Cr Type: 29% Cr, 9%Ni 1.3401, 1.4006, 1.4339, 1.4340, 1.4347, 1.4460, 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						
ZULASSUNGEN	CE						
SCHWEISSPOSITIONEN	   						
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	P	Cr	Ni	S
	0.12	0.6	1.2	0.025	29.5	9.5	0.015
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	
	As Welded		580	740	24	HRc	
RÜCKTROCKNUNG	140°C / 24 hr						
GAS ACC. EN ISO 14175	M21						



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AA 312 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417374