



# CEWELD AA 312

|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                         |                            |                         |           |          |       |
|--------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------------|-------------------------|-----------|----------|-------|
| TYPE                                                   | Rutile fluxcored welding wire developed for welding dissimilar steels with difficult weldability                                                                                                                                                                                                                                                                                                                                                                        |                         |                            |                         |           |          |       |
| APPLICATIONS                                           | Buffer layers before hardfacing, armor plate, exhaust systems, high, Manganese austenitic steel, heterogeneous welding, difficult to weld and unknown steels.                                                                                                                                                                                                                                                                                                           |                         |                            |                         |           |          |       |
| PROPRIÉTÉS                                             | 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                       |                            |                         |           |          |       |
| CONVIENT POUR                                          | <b>ISO 15608: 8 &gt;19% Cr Type: 29% Cr, 9%Ni</b><br>1.3401, 1.4006, 1.4339, 1.4340, 1.4347, 1.4460, 1.4762, 1.4085<br>X120Mn12, X10Cr13, GX32CrNi28-10, GX49CrNi27-4, GX8CrCrNiN26-7, X3CrNiMoN27-5-2, X 10 CrAl 24, G-X 70 Cr 29<br>UNS S41000<br>AISI 329, 410. S235, E295<br>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 |                         |                            |                         |           |          |       |
| AGRÉMENTS                                              | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                            |                         |           |          |       |
| POSITIONS DE SOUDAGE                                   |                                                                                                                                                                                                                                                                                                                                                                                      |                         |                            |                         |           |          |       |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Si                      | Mn                         | P                       | Cr        | Ni       | S     |
|                                                        | 0.12                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 0.6                     | 1.2                        | 0.025                   | 29.5      | 9.5      | 0.015 |
| PROPRIÉTÉS MÉCANIQUES                                  | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Hardness |       |
|                                                        | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                         | 580                        | 740                     | 24        | HRc      |       |
| ETUVAGE                                                | 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 |