



# 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**  
 1.4762, 1.4085  
 X120Mn12, X10Cr13, GX32CrNi28-10, GX49CrNi27-4, GX8CrCrNi26-7, 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**



**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

**MECHANISCHE GÜTEWERTE**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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