

ES 312-16

Type Acid-rutile

SMAW

E312-16

ESWECO
The Art of Welding

Description

ES 312-16 Can be used for joining hard to weld materials and dissimilar metals.

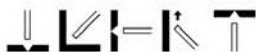
Applications should be limited to 800°F (420°C)

The weld deposits exhibit high tensile strength and offer some resistance to abrasion.

Typical application: Tool Steels, Hard to Weld Steels, Cast and Wrought Alloys and dissimilar Metals

Current

DC+, AC



Classifications

EN 3581-A	E 29 9 R
SFA/AWS A5.4	E312-16
Werkstoff Nr.	1.4337

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.12	0.58	1.4	29.3	9.5	0.15	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	610
Tensile strength, MPa	780
Elongation A5, %	23

Charpy V

Test temps, °C	Impact values, J
+20	30

Ferrite content FN 50-80

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	50-85	24
3.2	350	80-125	25
4.0	350	110-175	25
5.0	350	150-240	27