

**Classifications**

EN ISO 3581-A:2012	: E 29 9 R 12	KS D 7014	: E312-16
EN ISO 3581-B:2012	: ES312-16	JIS Z 3221	: ES312-16
AWS A5.4-06	: E312-16		

**Description**

- Covering is lime titania type for welding of 29%Cr-9%Ni type cast steels and difficult to weld steels. Joint welding and hardfacing of stainless steel and heat resisting steels.
- Good crack resistance because of extremely much quantity of ferrite of the deposited weld metal.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

**Welding positions****Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.08	0.45	1.30	0.028	0.012	8.49	29.13	0.10	0.11

**Typical mechanical properties of all-weld metal**

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 660	min. 22	
EN ISO 3581-A	min. 450	min. 650	min. 15	
Typical Values	510	760	25	AW
* AW : As-Welded				

**Sizes available and recommended currents (AC or DC +)**

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp. (A)	F V · OH	40~80 35~75	70~110 70~90	110~140 80~120	140~180 -

**Approvals**

CE