CEWELD®

AA 312

CATEGORY	FCAW Flux-Cored
TYPE	Rutile fluxcored welding wire developed for welding dissimilar steels with difficult weldabillity
APPLICATIONS	Buffer layers before hardfacing, armor plate, exhaust systems, high, Manganese austenitic steel, heterogeneous welding, difficult to weld and unknown steels.
PROPERTIES	Very good welding characteristics and not sensitive for cracks and fissures. High tensile strength with good corrosion and acid resistance. Scale resistance up to 1150ºC, 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: E 312 T0-1 A 5.22: E 312 T0-4 EN ISO T 29/9 RM3 (C3) DIN: W.Nr. 1.4337 DIN 8556: 29 9
SUITABLE FOR	Stainless steel, C45, C60, Manganese steel, Spring steel, Buffer layers! 25CrMo4, 42CrMo4, 50CrMo4, 42MnV7, 1.7218, 1.7225, 1,7228, 1.5223, AISI 4130, 4140, 4150 hss, high speed steel, stainless steel, cast steel, unknown steel, difficult to Weld steel, cock wheels,
APPROVALS	CE approved
WELDING POSITIONS:	

WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	FNW
0.12	1.20	0.60	29.5	9.5	50.7

MECHANICAL PROPERTIES

Heat treatment	RP0,2 (N/mm2)	Rm (N/mm2)	A5 (%)	Impact energy (J) ISO-V -20C	-40°C	-60C	Hardness HRc / HV
AW with M21	580	740	24				

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2			K-300	15	1080
1.6			K-300	15	1080

REDRYING TEMPERATURE	150°C/24hr
GAS ACC. EN ISO 14175:	M21