

PRODUCT DATA SHEET

Superweld 312



Superweld 312 is a rutile basic coated low carbon electrode of the 29% chromium, 9% nickel type. The structure is highly resistant to hot cracking and extremely tolerant of dilution from medium and high carbon steels, etc. Superweld 312 is a universal electrode specifically designed for welding steels

of low weldability. The electrode is suitable for welding austenitic manganese steel, medium and high carbon hardenable steels, tools, dies, springs, etc. which may be of unknown composition.

Classifications

AWS	A5.4	E312-16
ISO	3581-A	E29 9 R12
ISO	3581-B	ES 312-16

Typical Chemical Analysis

% Carbon	0,1	% Nickel	10,0
% Manganese	1,0	% Sulphur	0,01
% Silicon	0,85	% Phosphorous	0,03
% Chromium	28,5		

Typical Mechanical Properties (All weld metal in the as welded condition)

0,2% Proof Stress	600 MPa min
Tensile Strength	760 MPa min
% Elongation on 4d	22 min
Charpy V-Notch at +20°C	30 J min

Packing Data (DC+ AC 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number (multi-kg pack)
2,5	300	50 - 90	3 x 5,0	W085692
3,25	350	80 - 110	3 x 5,0	W085693
4,0	350	100 - 170	3 x 5,0	W085694

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