



WELDING ELECTRODE FOR STAINLESS STEEL

AWS 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 ferrite of the deposited weld metal.
- Redry the electrode at 250-350°C 30-60 minutes prior to use.

Chemical Composition of Deposited Metal : (%)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Standard	≤ 0.15	0.5-2.5	≤ 1.00	≤ 0.03	≤ 0.04	28-32	8-10.5	≤ 0.75	≤ 0.75
Typical	0.12	1.12	0.71	0.012	0.027	30.17	8.61	0.12	0.03

Mechanical Properties of Deposited Metal

	Tensile Strength σ_b (Mpa)	Elongation δ_5 (%)
Standard	≥ 660	≥ 22
Typical	700	28

Recommended Current (AC 、 DC)

Diameter(mm)	2.5	3.2	4.0	5.0
Length(mm)	300	350	350	350
Flat Current(A)	40-80	70-110	110-140	140-180
Vertical, Overhead Current(A)	35-75	70-90	80-120	