

Stainless Steel SMAW Electrodes

G312

AWS A5.4 E312-16
JIS Z 3221 ES312-16
ISO 3581-A-E 29 9 R

Product Features:

- All deposited weld metal contains approximately 29%Cr-9%Ni elements with higher ferrite content than others.
- Higher Cr content in weld metal than others to get good oxidation and crack resistance.

Applications:

- Welding of 29%Cr-9%Ni stainless steel castings.
- Suitable for dissimilar metal welding of stainless steel to low alloy steel or high Ni stainless steels.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Fe
0.11	0.72	1.04	10.0	28.5	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
745	816	27

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	60~85	85~120	115~150	150~200
Vertical / overhead position	50~75	75~105	95~120	----

Note:

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
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www.goodweld.com.tw