

Stainless Steel MIG•TIG Wire/Rod

GM312 / GT312

AWS A5.9 ER312
JIS Z 3321 YS312
ISO 14343-A-G 29 9
14343-A-W 29 9

Product Features:

- Austenite structure weld metal contains higher ferrite than other stainless steels.
- 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 steels or high Ni stainless steels.

Shielding gas:

- Ar+ 1~2% O₂ (MIG)
- 100%Ar (TIG)

Typical chemical composition of wire / rod (wt%)

C	Si	Mn	Ni	Cr	Fe
0.09	0.35	1.83	8.76	30.57	Bal.

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
700	34

MIG Size (mm) & recommended welding parameters; DC+

Diameter (mm)	0.9/1.0	1.2	1.6
Current range (Amp)	70~200	90~250	200~300

TIG rod size diameter/length; DC-

Diameter (mm)	1.6	2.0	2.4/2.6	3.2
Length (mm)	1000	1000	1000	1000

Note:

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