Selectarc Inox 312HR

Synthetic Electrode
For difficult to weld steels

Classification

AWS A5.4 : ~ E312-26
ISO 3581-A : E Z 26 9 R 7 3
DIN 8555 : E9-UM-250-KRZ

Description & Applications

Synthetic electrode with high recovery (160%). With a rutile coating, for overlaying and welding high strength steels with each other and with stainless steels. Also recommended for buffer layers before hardfacing and to weld galvanised steels. Highly resistant against cracks. Offers soft fusion, very little spatters, self releasing slag.

Base materials

Low alloyed steels, carbon steels, galvanised steels, high strength steels.
Stainless steels
Tools steels
Austenitic steels with Mn
Screening steels
Spring steels
Armatures and wire lattice for reinforced concrete

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
0.06	1.1	1.0	26.5	9.5	0.2	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	Hardness
>550	>700	>25	Approx. 240 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x350	3,2x350	4,0x450
Current	(A)	50-80	70-100	100-140	150-200

Redrying 1 hour at 300°C. Preheating of base materials with a high carbon equivalent to 100-250°C.

ind.12



= +	~ 50V

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