

Classification

AWS A 5.9 : ER 312

EN ISO 14343 : W 29 9

Typical weld metal chemical composition (%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.15 max.	1.50-2.20	0.30-0.65	28.00-32.00	8.00-10.50	0.75 max.	0.75 max.	0.03 max.	0.03 max.

All weld metal mechanical properties (typical)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact energy ISO-V(J) 20°C
≥ 450	≥ 650	≥ 22	≥ 47

Description

ITR 312 is a stainless TIG rod suitable for welding or surfacing difficult to weld steels. Suitable for welding buffer layers. The excellent mechanical properties and the notch toughness make SUPERTIG 312 suitable for a wide range of applications.

Materials to be welded

Dissimilar and difficult to weld steels.

Current conditions

DC (-)

Storage

Keep dry and avoid condensation

Packing data

Size (mm) DxL	0.80 x 1000	0.90 x 1000	1.00 x 1000	1.20 x 1000	1.60 x 1000	2.00 x 1000	2.40 x 1000	3.20 x 1000	4.00 x 1000
Net wt. per tube (kg)	5	5	5	5	5	5	5	5	5
Net wt. per box (kg)	20	20	20	20	20	20	20	20	20

Welding positions

