

Stainless Steel SMAW Electrodes

KE 312

AWS A5.4 E312-17
EN 1600 - E 29 9 R 32
JIS Z 3221 ES312-17

Product Features:

- Rutile type electrode provide smooth arc transfer in the flat and horizontal positions.
- With 29%Cr-9%Ni deposited metal to form higher ferrite content aids to get good oxidation and crack resistance.
- Superior welding characteristics including good slag removal, smooth and clean weld bead appearance, higher current carrying capacity and less spatter formation.

Applications:

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

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	P	S
0.10	0.81	1.11	10.26	28.8	0.018	0.008

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
819	23.3

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	110~150	150~190
Vertical / overhead position	50~70	75~105	95~120	----

Note:

ecoweld®

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