

ROYAL 312 (E 312-16)

AWS A/ SFA 5.4 E 312- 16 IS : 5206 - 1983 E 29.9 R 16 EN ISO 3581 A E 29 9 R 12

Applications

Suitable for welding of Heavy machinery parts, earth moving equipments, automobile spring, trumions of cement mill and other allied components, parts subject to corrosion and impact. Joining and surfacing of High Carbon, low and high alloy steel, tool steel, spring steel, manganese steel, case hardening steel, high speedsteel, cost steel etc 301, 302, 304, & 308 types.

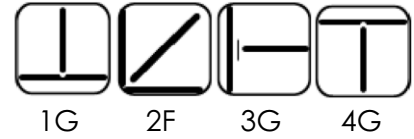
Characteristics on Usage

A medium heavy coated rutile type all position electrode giving 30 % Cr. And 10 % Nickel weld deposit. The electrode has very soft arc and gives smooth and defect free austeno ferritic weld metal. Almost no distortion and embrittlement of the base material. The weld metal is resistant to friction, heat and corrosion is work hardening and shockproof gives radiography weld deposit.

Packing

Vaccum Pack

Welding Positions



Notes On Usage

- ⌚ Dry the electrodes at 350° C for 60 min. before use.
- ⌚ Keep the current as low as possible.
- ⌚ Remove rust, water, oil, paint etc. from groove.

STAINLESS STEEL ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%
0.15 Max	0.50 - 2.50	1.00 Max	0.030 Max	0.040 Max	28.0 - 32.0	8.0 - 10.50	0.75 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
660	22

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 x 350	2	10	4.40	22.05	50 - 70	AC /DC + Ve
3.20 x 350	2	10	4.40	22.05	70 - 100	
4.00 x 350	2	10	4.40	22.05	100 - 130	
5.00 x 350	2	10	4.40	22.05	130 - 160	