

DAIKOFCW 312



AUSTENITIC STAINLESS STEELS

312

DESCRIPTION

Rutile flux cored wire for flat and horizontal position

Austenitic rutile flux cored wire for welding and cladding in flat and horizontal position. The easy handling and the high deposition rate result in high productivity, excellent welding performance and very low spatter formation. The wire shows good wetting behaviour and a finely rippled surface pattern. This consumable is used to weld similar steels, medium and high carbon hardenable steels. This product has extreme tolerance to dilution and it is useful to weld unknown specification steels.

SPECIFICATIONS

ISO 17633-A	T 29 9 R M21 3	AWS A5.22	E312T0-4
DIN	-	Werkstoff Number	-
Certifications	-	Shielding	M21
Positions	PA, PB, PC	Current	DC+

ASME QUALIFICATIONS	FERRITE	PREN	HARDNESS
F-No (QW432) 6	% 40	28.4	300HV
A-No (QW442) 8			

CHEM. COMP. %	DEFAULT	MECHANICAL PROPERTIES	MIN	VARIANT
C	0.12	Tensile strength R _m MPa	650	740
Mn	1.2	Yield strength R _{p0.2} MPa	450	580
Ni	10.2	Elongation A (L ₀ =5d ₀) %	15	22
Cr	28.4	Impact Charpy ISO-V	-	-
P	0.02	Impact Charpy ISO-V	-	-
S	0.008			
Si	0.6			

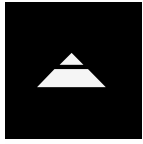
WELDING PARAMETERS	1.2 mm	1.6 mm
Ampere	120A - 280A	200A - 350A
Voltage	22V - 30V	26V - 30V
Packaging	Ø 1,2÷1,6mm	Ø 1,2÷1,6mm
Packaging Type	BS300 spool	BS300 spool



The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit www.daikowelding.com.



V 01/2024



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APPLICATION

Suitable for welding medium and high carbon hardenable steels, including those with known or unknown specifications like tool steels, shafts, gear teeth, free-cutting steels, dissimilar alloy combinations, buffer layers, overlays, etc. The welding material, featuring a high alloy and high ferrite content (40-50FN), exhibits exceptional tolerance to dilution on a wide range of hardenable and alloy steels, often requiring minimal or no preheat. It is effective for welding free-cutting steels or those with a low Mn:S ratio, especially below 20, preventing hot cracking due to liquation at the fusion boundary. The resulting weld deposit work-hardens, offering excellent wear and friction resistance. It is useful for corrosion resistance and high-temperature scaling up to about 1000°C. However, it's not recommended for structural applications above 300°C or for welds that undergo post-weld heat treatment due to potential embrittlement. Additionally, it is not suitable for filling up heavy joints, sub-zero applications, or situations requiring high notch toughness.

ALLOY TYPE

Austenite-ferrite weld metal composition of nominally 29%Cr-9%Ni for dissimilar joints and difficult to weld steels.

MICROSTRUCTURE

Duplex austenite-ferrite microstructure with about 40% ferrite.

MATERIALS

Medium and high carbon hardenable steels, tool steels and free-cutting steels.

WELDING & PWHT

The procedure is contingent upon the base material. Preheating is generally unnecessary for small components and buffer layers; however, it is advisable for thicker high-carbon steels to prevent potential Heat-Affected Zone (HAZ) quench cracking and regulate peak hardness, typically in the range of 100-250°C. Despite the excellent high-temperature oxidation resistance of 29%Cr-9%Ni alloys, it's crucial to note that duplex high ferrite weld metal may experience 475°C embrittlement above approximately 300°C and sigma embrittlement at elevated temperatures. Consequently, this alloy is not employed in applications involving high-temperature structural service or Post Weld Heat Treatment (PWHT).

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