



G-TECH 312R

SMAW

AUSTENITIC STAINLESS STEELS

312

DESCRIPTION

Rutile coated electrode for similar steels, medium and high carbon hardenable steels

Electrode is suitable for difficult to weld steels. e.g. constructional steel with high tensile strength, cladding of rail steels, fusion welding of high alloyed manganese steels and joints off this steels with high alloyed steel. Suitable for repair and maintenance for maximum working temperature up to 1150° C. Its rutile coating ensures excellent weldability in all positions, except for vertical down, and a high resistance to cracking providing smooth arc transfer. Virtually self-cleaning slag produce a concave bead with minimal ripple as well as a smooth and clean weld profile.

SPECIFICATIONS

ISO 3581-A	E 29 9 R 12	AWS A5.4	E312-17
DIN	-	Werkstoff Number	-
Certifications	-	Shielding	-
Positions	PA, PB, PC, PD, PE, PF	Current	DC+, AC

ASME QUALIFICATIONS

F-No (QW432)	5
A-No (QW442)	8

FERRITE

% 40

PREN

29

HARDNESS

300HV

CHEM. COMP. %

DEFAULT

C	0.09
Mn	1
Ni	10
Cr	29
Si	1.15

MECHANICAL PROPERTIES

	MIN	VARIANT
Tensile strength R_m MPa	650	700
Yield strength $R_{p0.2}$ MPa	450	600
Elongation A ($L_0=5d_0$) %	15	22
Impact Charpy ISO-V	-	30J @ 20°C
Impact Charpy ISO-V	-	-

WELDING PARAMETERS

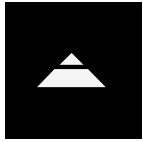
	2 mm	2.5 mm	3.2 mm	
Ampere	35A - 50A	50A - 80A	80A - 110A	110A -
Voltage	-	-	-	
Packaging	88 pcs/kg	56 pcs/kg	28 pcs/kg	18 p
Packaging Type	Carton box	Carton box	Carton box	Carto

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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.

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DESCRIPTION

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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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