

TI 312

TIG Welding Wire - Stainless Steels

Standards

AWS/ASME SFA - 5.9	ER312
EN ISO 14343 - A	W 29 9
TS EN ISO 14343 - A	W 29 9
DIN M. No.	1.4337

Properties and Applications

Austenitic-ferritic stainless steel wire electrode for TIG welding of dissimilar steels and depositing buffer layers on ferritic steels. It features high resistance to cracking and toughness, is therefore suited for joining difficult to weld steels and depositing stress-relaxing buffer layers on crack sensitive base metals. Weld metal is non-scaling up to 1100°C. Especially used in die and tool repair, crack repairs in difficult to weld steels, gear teeth repair and rebuilding, buffer layer application on cutting blades. Suitable also for welding galvanized steel plates.



Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni
Welding Wire	0.10	0.40	1.80	30.00	9.00

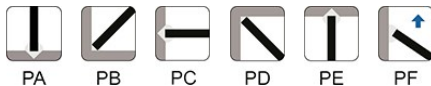
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	I1	700	770	21	20°C → 60

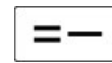
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
2.00x1000
2.40x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23105HBKM2	2.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
23105IBKM2	2.40x1000	5 kg	5.30	4	21.40	Cardboard Tube

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.