

MI 312

Gazaltı (MIG/MAG) Kaynak Teli - Stainless Steels

Standards

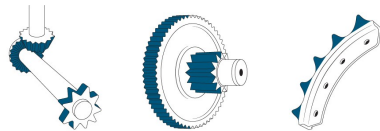
AWS/ASME SFA - 5.9	ER312
EN ISO 14343 - A	G 29 9
TS EN ISO 14343 - A	G 29 9
DIN M. No.	1.4337

Properties and Applications

Austenitic-ferritic stainless steel wire electrode for GMA (MIG/MAG) 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 Applications



Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni
Welding Wire	0.01	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	M13	550	740	25	20°C → 80

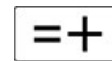
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M13 (Ar+%0,5-3 O2) .

Application Information

Welding Positions



Polarity:



Protection Gas:

M13 M12 M14 I1

Welding Parameters & Efficiency

Diameter (mm)
0.80
1.00
1.20
1.60

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23005BJAM2	0.80	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

23005DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23005EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23005GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.