

EI 312

Coated Electrode for Stainless Steels -

Standards

AWS/ASME SFA - 5.4	E312-16
EN ISO 3581 - A	E 29 9 R 12
TS EN ISO 3581 - A	E 29 9 R 12
DIN M. No.	1.4337

Approvals & Certificates

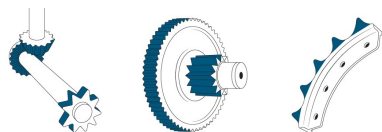
TUV	GOST	CE
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Properties and Applications

Rutile type stainless steel electrode for joining dissimilar steels and depositing claddings on ferritic steels. The ferritic-austenitic Cr-Ni weld metal contains approximately 50% of delta-ferrite and is non-scaling up to +1100°C. It features high resistance to cracking and is therefore suited for joining difficult to weld steels and depositing stress-relaxing buffer layers on crack sensitive base metals. Especially used in crack repair and build-up of tool and die steels, rebuilding of worn or cracked gear teeth, buffer layer on cutting blades. Suitable for welding galvanized steel plates. Possible to use equally well both AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joints faces, finely rippled bead surface, easy slag removal.



Typical Applications



Typical Chemical Values of Weld Metal

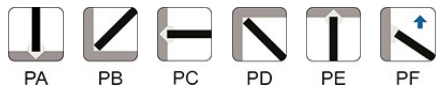
Type of Analysis	C	Si	Mn	CR	Ni
Weld Deposit	0.10	0.60	1.00	29.50	9.00

Typical Mechanical Values of Weld Metal

Test Condition	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	780	23	20°C → 50

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.00x300	30-60
2.50x300	50-80
3.25x300	80-120
3.25x350	80-110
4.00x350	110-160
5.00x350	160-220

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
13015DJEM2	2.00x300	140 AD	1.79	9	16.30	VAC Box
13015GJEM2	2.50x300	98 AD	1.79	9	16.30	VAC Box
13015MJEM2	3.25x300	60 AD	1.79	9	16.30	VAC Box
13015NJEM2	3.25x350	59 AD	2.04	9	18.60	VAC Box
13015QJEM2	4.00x350	40 AD	2.04	9	18.60	VAC Box
13015TJEM2	5.00x350	25 AD	2.04	9	18.60	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
It has to be dried at 350°C for 2 hours.