

PRODUCT DATA SHEET

TIG WIRE - PROWELD - 312/ (1.4337)

Classification: AWS / ASME – A/ SFA 5.9 ER 312
BS EN 14343: 2009 – W29.9.

Typical Applications:

Proweld 312 is primarily used for welding difficult to weld steels. The deposition is 29 Cr /9 Ni austenitic/ferritic weld metal.

The weld metal exhibits excellent strength, heat and oxidation resistance even with dilution from difficult to weld materials, like tool and die spring steels, steels, free cutting, high temperature steels. Also recommended for dissimilar joints and

surfacing.

Wire Composition: (%)

	C	Mn	Si	Cr	Ni	S	P	Mo
min	-	1.0	0.30	28.0	8	-	-	
max	0.15	2.5	0.65	32.0	11	0.03	0.03	0.30

Mechanical properties (Typical as Weld):

Tensile Strength	760N/mm ²
Yield Strength	560 N/mm ²
Elongation A5	25%
Impact energy(20° C)	45J
Hardness	230BHN

Ferrite content:

Ferrite Number about 40– WRC-92

Welding Parameters

The information will be provided on request.

Shielding Gas:

I1 Pure Argon 5-10 L/min

M13 Argon+1-3% O₂, 5-10 L/min

Corrosion resistance:

Good resistance to general corrosion and to moist sulphuric environments.

Packaging Detail:

Diameter : 0.80,1.00,1.20,1.60, 2.0, 2.40, 3.20, 4.0 mm*
Length : 1000 mm (36")

Packing : 5 Kgs in Spiral Tubes/Plastic, then in a Master Carton of 25 Kg(5x5)**

Also available in AWS standard diameters

Marking:

Both ends embossed with grade and diameter for the diameter >=1.60mm