

CLASSIFICATIONS

EN ISO 14343-A : G 29 9

EN ISO 14343-A : W 29 9

AWS A5.9 : ER 312

DESCRIPTION

- Applicability in joint- welding of unalloyed and alloyed high-strength steels, Cr and Mn steels, tool steels, and of different metals
- Resistance to wearing, cracking and corrosion
- Requirement of use of Ar as shielding gas in TIG welding, and Ar+ %2.5 O₂ or Ar+ %2.5 CO₂ mix as shield gas in MIG welding

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.12 | Si: 0.40 | Mn: 1.80 | Cr: 30.0 | Ni: 9.0

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 450	min. 660	47 J	min. 20

BASE MATERIALS

DIN:		AISI:
X7Cr13	G-X 7 Cr 13	403
X7CrAl13	G-X 20 Cr 14	405
X10CrAl13	G-X 10 Cr Mo 13	410
X 8 Cr17	G-X 8 Cr Ni 13	420
X20Cr13		430
X 15Cr 13		430 Ti
X22CrNi17		431
X15CrNi134		446
X 8 Cr Ti 17		

WELDING POSITIONS



CURRENT CONDITION

TIG D.C.(-) / MIG D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100043	0,8	0.030"	15	BS 300
1011100044	1	0.040"	15	BS 300
1011100045	1,2	0.047"	15	BS 300
1011100046	1,60 x 1000	1/16 x 39"	5	Plastic Box
1011100047	2,00 x 1000	5/64 x 39"	5	Plastic Box
1011100048	2,40 x 1000	3/32 x 39"	5	Plastic Box