

KS-312

Classification

AWS A 5.4/A5.4M E312-16

AS/NZS 4855 B ES312-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 30%Cr-9%Ni.
- (2) Superior weldability, low spatter, easy slag removal and smooth beads.
- (3) Low crack susceptibility. It is suitable for welding stainless steel sheet linings, dissimilar metals, alloy steels with high hardenability, and hard-to-weld steel.

Welding Position

All Position

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni
0.420	0.68	1.64	0.013	0.008	26.70	20.46

Typical Mechanical Properties of Weld Metal

Tensile Strength MPa	Yield Strength MPa	Elongation %
780	610	25

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.6x300	3.2x350
Amp	F/H-Fillet 50~85	80~120
	V-up/OH 45~85	70~110

Diam.	Pack / Carton	Part No.
2.5mm	2.5kg Tube x 12 = 30 kg	KS31225
3.2mm	2.5kg Tube x 12 = 30 kg	KS31232

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