

KT-312

Classification

AWS A5.9/A5.9M

ER312

Applications and Features

- (1) Weld metal is austenite structure with 30%Cr-9%Ni.
- (2) Superior crack resistance and high strength due to high ferrite content
- (3) Good corrosion resistance at high temperature due to high Cr content.
- (4) It is suitable for welding dissimilar metals, clad steel, stainless steel sheet linings, alloy steel with high hardenability and may be used as buffer layer before hardfacing.

Typical Chemical Composition (wt%)

C	Si	Mn	P	S	Cr	Ni
0.12	0.48	1.64	0.012	0.010	29.81	8.78

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar)

Tensile Strength MPa	Yield Strength MPa	Elongation %
720	580	29

Sizes and Suggested Operating Range

Size mm	Current A	Gas Flow L/min	Shielding Gas
16	75-100	25	Ar
24	150-200	25	Ar

Diam.	5 kg Tube
1.6mm	KT31216
2.4mm	KT31224

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