

# K-312T

Austenitic Stainless welding wire (dissimilar joints, Buffer layer)

## Classifications

EN ISO 17633-A:2008	: T 29 9 P C 1	AWS A5.22-15	: E312T1-1
EN ISO 17633-B:2008	: TS312-FC1	JIS Z 3323	: TS312-FC1

## Description

- K-312T is formulated for MAG welding of 30%Cr-9%Ni stainless steels and It is used for joining dissimilar steels, steels with reduced weldability and buffer layers prior to hardfacing (rolls, forging dies, hotwork tools, dies for plastics and so on)
- Wire is a titania type of flux cored wire for all-position welding and It also provides excellent usability with stable arc, less spatter levels, better bead appearance as the same as that of a solid MIG wire.
- It has resistance to stress corrosion and highly insensitive to dilution and good scaling resistance up to 1150°C.

## Welding positions



## Polarity & shielding gas

- CO<sub>2</sub>: 100% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

## Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO <sub>2</sub>	0.06	0.55	1.25	30.30	10.06	60 ~ 80

## Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.22		min. 660	min. 22	
EN ISO 17633-B	min. 450	min. 660	min. 15	
Example	600	760	25	CO <sub>2</sub>

## Notes on usage and welding condition

- Refer to page 303 for more information on usage
- When heat input is excessive, base metal will be bended or distorted due to the bad heat conductivity. Therefore, perform welding with selecting proper heat input

## Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		