

# Gas Metal Arc Welding

JIS Z3321 Y312  
 AWS A5.9 ER312  
 DIN 8556-SG 1.4337

## MS M-312 Solid Wires for Stainless Steel

**Applications** Suitable for welding of dissimilar metals such as stainless steel, carbon steel and low alloy steel. MS M-312 has excellent usability and weldability. Owing to the austenite structure containing large contents of ferrite, MS M-312 has good crack resistibility steel.

Brand Name		MS M-312								
Representative of diameter (mm)		0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo		
	≤ 0.15	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	8.0-10.5	28.0-32.0	-	-	-
Mechanical property of deposited metal										
Tensile strength	≥ 550 N/mm <sup>2</sup>									
0.2% Offset strength	≥ 225 N/mm <sup>2</sup>									
Elongation	≥ 35 %									
Impact test	NA									
Welding position	Horizontal/Flat position									
Welding polarity	DC-EP									
Shielding gas	98%Ar - 2%O <sub>2</sub>									
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm					
	80-180A	120-200A	140-250A	170-300A	200-350A					
Packing	12.50 kgs standard other packing weight can be provided upon request.									