

716-6357 to 716-6370

Nicrex E312



BS 2926, 1984 . 29.9 AR
AWS A/SFA 5 4-92 : E312-17 nearest

Description and applications

This is a highly alloyed stainless steel electrode of unusual versatility. It deposits a ferritic/austenitic duplex weld metal with about 40% ferrite content. The weld deposit is resistant to stress corrosion attack and is highly insensitive to dilution with parent metal.

Typical applications include the welding of dissimilar steel combinations such as mild or low alloy steel to stainless steel, and the welding of spring steels, nickel steels, other hardenable steels. Examples of applications include dies for plastics extrusion, surfacing of rails, building up forging dies. The weld deposit shows good scaling resistance up to 1150°C.

Equivalent consumables

include Murair 20/9/3 (self-shielded cored wire), and
Corofil 20/9/3 (flux-cored wire)

All-weld metal properties

Composition wt%		Mechanical	As-welded	
C	0.15 max	0.2% PS	400 min	N/mm ²
Si	0.7-1.2	UTS	660 min	N/mm ²
Mn	0.5-1.2	Elongation	22 min	%
S	0.020 max	CVN at +20°C	40 typical	J
P	0.030 max	Ferrite level	40-45	%
Cr	28.0-30.0			
Ni	9.5-10.5			

Current range AC (min OCV 50) or DC +

Size	mm	2.5	3.2	4.0	5.0
Current	amps	60-90	80-120	110-170	140-230

Packaging

Item No	Size mm	Length mm	Approx. wt. 1000 pcs.kg	Contents per carton	
				Pieces	Approx. wt. kg
6695252030	2.5	300	18	498	9.0
6695323030	3.2	350	36	300	10.8
6695403030	4.0	350	53	204	10.8
6695503030	5.0	350	80	150	12.0