

TIGFIL 312 / MIGINOX 312

Classification

AWS A/SFA 5.9 ER 312

Characteristic

A 30Cr, 9Ni stainless steel wire for TIG/MIG welding of cast alloys of similar composition. This alloy gives a two phase weld deposit with substantial percentage of ferrite in an austenitic matrix; the microstructure is therefore highly resistant to weld metal cracks and fissures.

Typical Application

It is very useful in welding dissimilar metals such as carbon steel to stainless steel, particularly those grades high in nickel. It is used for joining and overlaying a variety of metals; carbon steels, spring steels, tool and die steels, and various alloy steels. Because of the high ferrite, little welding to two or three layers only when welding similar cast alloys.

Wire Chemistry

C	S	P	Mn	Si	Cr	Ni	Mo	Cu
0.15 max	0.03 max	0.03 max	1.0-2.5	0.30-0.65	28.0-32.0	8.0-10.5	0.75 max	0.75 max

Properties of weld metal with 100% Argon gas shielding Current Condition: TIG : DC (-) MIG : DC (+)

Classifications:

All Weld Mechanical Properties As welded condition

UTS MPa 660 min

Elongation % (L=4xd) 22 min

The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas used.

Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 15 Kg

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

Packing Specifications for MIGINOX 312

Dia., mm	0.8	1.2	1.6	2.0
Net wt per spool,kg	12.5	12.5	12.5	12.5

Packing Data for TIGINOX 312

Dia., mm	1.0	1.2	1.6	2.0	2.5
Length,mm	1000	1000	1000	1000	1000
Net wt per tube,kg	5	5	5	5	5
No of Plastic Tubes per Box	4	4	4	4	4
Net wt,Box,kg	20	20	20	20	20



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