



HILCO HILCHROME 312R

Stick electrodes – stainless steel – special purpose

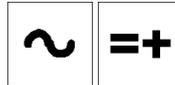
AWS A5.4: ~E312-17

EN ISO 3581-A: E 29 9 R 3 2

Werkstoffnr. 1.4337

Coating type:
Rutile

Current:



Welding positions:



Hilchrome 312R is our rutile coated electrode which is to be considered as a problem solver for all kinds of steel grades including stainless and difficult-to-weld steels. Typical applications for this WELD-ALL include joining hard manganese steels, tool steels, spring steels, buffering as well as joining dissimilar steel grades. The electrode deposits a crack-resistant weld metal with an increased ferrite content of approx. FN50. Hilchrome 312R is a core wire alloyed all-current type (AC/DC).

Base materials to be welded:

- Armour plate
- Hardenable steels incl. DFTW-steels
- Tool, die and spring steels
- Austenitic manganese steels
- Hardfacing clutches, gear wheels, shafts
- Buffer layers prior to hardfacing
- Dissimilar joining

Applications:

- Repair & Maintenance
- Transport & Lifting Industry

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	Cr	Ni
0,11	0,7	1,1	28,8	9,5

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	650	790	24	20°C 30

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	300	17,5	60-80
3,2	350	32,3	80-110
4,0	350	47,8	110-140