



S. R. Industries

STAR ARC ER312

ER312 stainless steel wire is used for welding cast alloys of similar composition as well as dissimilar metals including stainless to mild steels. It can also be used for welding high strength steels. This alloy has very high ferrite.

AWS Specification : AWS A5.9/A5.9M:2006

<i>AWS Classification</i>	<i>ER312</i>
<i>Welding Current</i>	<i>DCEP</i>
Typical Wire Chemistry	
<i>C</i>	<i>0.15</i>
<i>Cr</i>	<i>28.0 - 32.0</i>
<i>Ni</i>	<i>8.0 - 10.5</i>
<i>Mo</i>	<i>0.75</i>
<i>Mn</i>	<i>1.0 - 2.5</i>
<i>Si</i>	<i>0.30 - 0.65</i>
<i>P</i>	<i>0.03</i>
<i>S</i>	<i>0.03</i>
<i>Cu</i>	<i>0.75</i>
Typical Mechanical Properties (As Welded)	
<i>Yield Strength, ksi</i>	<i>78</i>
<i>Tensile Strength, ksi</i>	<i>109</i>
<i>Elongation%, min</i>	<i>45</i>
<i>Welding Positions</i>	<i>F,V,OH,H</i>

Address : C-617, DSIIDC, Narela, Delhi-110040 India

Tel : 011 47506585 **Mobile :** + 91 9911166585

E.Mail : srindus@yahoo.com

Website : www.stararc.in



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<i>Available Diameters MIG with Operating Range in Amps</i>	
<i>.023"</i>	<i>35 - 70</i>
<i>.030"</i>	<i>50 - 100</i>
<i>.035"</i>	<i>160 - 210</i>
<i>.045"</i>	<i>180 - 250</i>
<i>Available Diameters TIG with Operating Range in Amps</i>	
<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>
<i>5/32"</i>	<i>170 - 350</i>

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