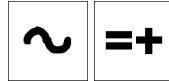


Coating type:

Rutile

Arc Voltage: 65V

Current:



Tip colour:

-

Welding positions:



Printing:

Hilchrome 312R / E312-17

Hilchrome 312R is our rutile coated electrode which is to be considered as a problem solver for all kinds of steel grades incl. 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

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	-	-	-	-	-

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,10	0,70	1,20	≤ 0,020	≤ 0,025	28,5	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	≥ 800	≥ 22	+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	80-120
4,0	350	47,8	110-145