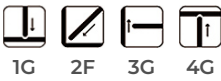


S-312.16

Classification

- AWS** A5.4/ASME SFA-5.4 E312-16
- JIS** Z 3221 ES312-16
- EN** ISO 3581- A E 29 9 R
- KS** D7014 E312-16

Welding Positions



Features

- Good crack resistance
- Excellent buffer effect against stress
- Easy to remove slag

Polarity

AC or DC+

Application Areas

- Welding of dissimilar steels
- Buffer layer for bulid-up

Redrying Conditions

350°C (662°F) X 1hr

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo
0.10	0.55	0.7	0.025	0.011	0.09	10.3	28.3	0.12

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)
803(117)	25

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.0 (5/64)	300 (12)	25~55	20~50	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
2.6 (3/32)	300 (12)	50~85	45~80	
3.2 (1/8)	350 (14)	70~115	65~110	
4.0 (5/32)	350 (14)	95~145	85~135	
5.0 (3/16)	350 (14)	135~180	-	

SMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux