

Description and Application

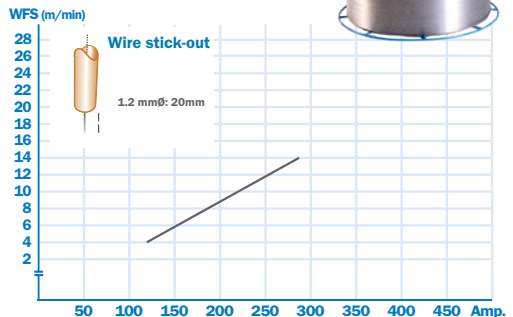
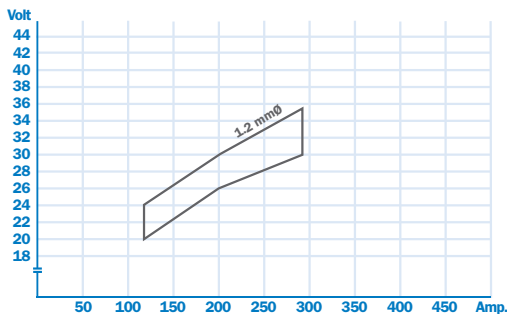
This rutile flux cored wire welds with a stable and almost spatter free arc to produce a shiny, bright, smooth weld bead surface with self-releasing slag.

Excellent crack resistance is due to a combination of high alloy and high ferrite content, which gives extreme tolerance to dilution on a wide range of hardenable and alloy steels with minimum or no preheating. The weld deposit also work-hardens and provides good wear and friction resistance.

DW-312 is applied for welding medium and high carbon hardenable steels, of known or unknown specifications, for example tool steels, shafts, free-cutting steels, dissimilar alloy combinations, overlaying, buffer layers prior to hard facing.



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

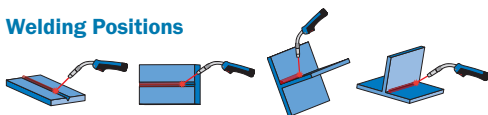
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.12	0.60	1.20	0.018	0.006	10.2	28.4	-	-	-	60.0	>18.0	50.7

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)°C
Guaranty	min.450	min.660	min.15	-

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	CE

