

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 312 is a stainless steel solid wire suitable for welding or surfacing difficult to weld steels. Suitable for welding buffer layers when hardfacing. The excellent mechanical properties and the impact toughness mean that this wire is suitable for a wide range of applications.

Classification	
AWS	A5.9: ER 312
EN	12072: G 29 9

Approvals	Grades
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Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.10	1.80	0.40	≤ 0.030	≤ 0.020	29	9	-	-	-	-	12-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 450	≥ 650	≥ 22	≥ 47	-

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

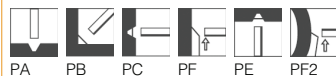
Dissimilar and difficult to weld steels

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: BS300 Kg. 15

Diameters	0,8	1,0	1,2			
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