

Cored Wires Stainless and Heat resistant steels

Fluxinox 312-PF is an alloyed rutile flux cored wire with a fast-freezing slag for joining and surfacing of dissimilar steels, as well as galvanized steels. The ferritic-austenitic weld metal (Delta-ferrite approximately 50%) is non-scaling up to 1100 °C. Fluxinox 312-PF is characterized by outstanding, almost spatter-free, welding properties. It produces finely rippled flat and smooth welds, free of undercut with very easy slag removal. Fluxinox 312-PF is mainly used for joining dissimilar steels, difficult-to-weld steels, e.g. heat treatable steels, tool steels and high manganese steels, and for surfacing or repair welding. Due to the fast-freezing slag, Fluxinox 312-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
AWS	A5.22: E312T1-4/E312T1-1
EN	12073: T 29 9 P M 1 / T 29 9 P C 1

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.15	1.30	0.90	-	-	29	9	-	-	-	-	-

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	≥ 660	≥ 25	≥ 32	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

Materials

Dissimilar and difficult to weld steels

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+				
				
PA	PB	PC	PF	PE

Packaging data: K300 kg, 16

Diameters	1,2				