

312S94

SAW

SOLID WIRE FOR SAW

PRODUCT DESCRIPTION

Solid wire for sub-arc welding.

CLASSIFICATIONS

AWS A5.9M	ER312
ISO 14343-A	29 9
ISO 14343-B	SS312

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.	--	1.0	0.30	--	--	28.0	8.0	--	--
max.	0.15	2.5	0.65	0.02	0.030	32.0	10.5	0.3	0.3
Typical	0.1	1.8	0.4	0.005	0.02	30	9.3	0.1	0.1

ALL-WELD MECHANICAL PROPERTIES

Typical values as welded

Tensile strength [MPa]

0.2% proof strength [MPa]

Elongation (%) 4d

5d

Reduction of area %

Impact ISO-V(I) +20°C

Hardness HV

TYPICAL OPERATING PARAMETERS

Flux	Current	Diameter (mm)	Parameters
P2007	DC+	2.4	350A, 30V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
2.4	25	B415	SA312S94-24