

312S94

TIG (GTAW)

SOLID WIRE FOR TIG

PRODUCT DESCRIPTION

Solid rod for TIG

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

As welded	Typical
Tensile strength [MPa]	790
0.2% proof strength [MPa]	640
Elongation [%] 4d	21
5d	19
Reduction of area %	35
Impact ISO-V[<i>J</i>] +20°C	50
Hardness HV	275

TYPICAL OPERATING PARAMETERS

Shielding	Current	Diameter [mm]	Parameters
Ar *	DC-	2.4	120A, 14V

* Also required as a purge for root runs.

PACKAGING DATA

Diameter [mm]	Weight [kg]	Packaging	Item number
1.6	2.5	PE TUBE	T312S94-16
2.4	2.5	PE TUBE	T312S94-24