

Classifications

EN ISO 14343-A	AWS A5.9 / SFA-5.9
S 29 9	ER312

Characteristics and typical fields of application

Solid wire for submerged arc welding, designed for welding of C/Mn – steels, high strength steels, spring steels, creep resistant steels and other difficult-to-weld steels. It is also suitable for dissimilar joints between stainless and mild steels.

The all-weld metal provides a high tensile strength and wear resistance as well as an excellent resistance to cracking.

Very good corrosion resistance in wet sulphuric environments e.g. in sulphate digesters used by the pulp and paper industry.

Structure: Austenite with 40 – 60 % ferrite

Scaling temperature at 850 °C (air)

Typical analysis of the wire

	C	Si	Mn	Cr	Ni
wt.-%	0.10	0.40	1.9	30.0	9.0

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	Marathon 805 (Avesta Flux 805)	S A AF 2 DC

Packaging

Size(s) in mm	Type	Weight
2,4	basket spool	25 kg

Other sizes and coil weights on request.

