



Nevatia Steel & Alloys Pvt. Ltd.
Office : 904,Lodha Supremus,9th floor
Worli, Mumbai ,India - 400018.
Web:<http://www.nevatiasteel.com>



TD-Stainless Welding wire
Revision No.: 02
Date of Issue : 01.11.2019

IATF 16949 , ISO 9001, ISO 14000 and ISO 45001 Certified
Company

Stainless steel welding wire -Technical data

Product Name : nevinox[®]MIG312

Product Specifications : ER 312

Grade	Equivalent Standards		
	AWS A5.9/5.9M	EN ISO 14343 A	EN ISO 14343 B
ER 312	ER 312	22 9	312

Characteristics : ER 312 gives a two-phase stainless steel weld deposit with about 30% austenite and ferrite matrix. Properties are highly resistant to weld metal cracking and fissures while yielding high strengths and good wear/corrosion resistance.

Application : ER312 stainless steel wire is used for welding cast alloys of similar composition as well as dissimilar metals including stainless to mild steels. It can also be used for welding high strength steels. This alloy has very high ferrite.

Chemical Composition % (Solid wire)

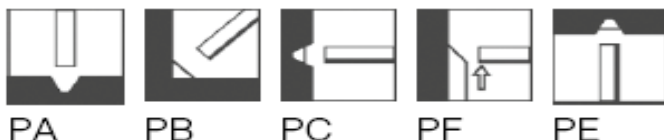
C	Mn	P	S	Si	Cr	Ni	Mo	Cu
0.15	1.30 - 2.10	0.030	0.020	0.30 - 0.65	28.00 - 32.00	8.00 - 10.00	0.50	0.50

Remarks: Single values shown in the table are maximum values. Two values shown indicate minimum and maximum limits for a range.

Current Conditions:- DC (+)

SHIELDING GAS: welding with 98% Ar – 2% O₂

Welding position: -





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Dimension & Packing Data

Size(mm)	Size(inch)	SD100 Spool packing 1kg/2lb	SD200Spool packing 5kg/10lb	SD300/BS300 Spool packing 12.5kg,15kg /25lb, 33lb	Drum packing 100kg,250kg/ 200lb, -550 lb
0.600	0.024	√	√	-	-
0.800	0.030	√	√	√	√
0.900	0.035	√	√	√	√
1.000	0.040	√	√	√	√
1.200	0.045	√	√	√	√
1.600	0.063	√	√	√	√

Diameter tolerance and ovality

- As per AWS A5.9 and ISO 544

Inspection & certification

- As per EN 10204 type 3.1

For more details please contact : sales@nevatiasteel.com.