



Nexus 312

29%Cr 9%Ni - Stainless Steel electrode for MMA welding

Rutile Stainless Steel electrode for the joining of dissimilar steels, low alloy and Stainless steel to themselves and each other at maximum service temperature of 420°C. Producing butt welds and mitre finish fillet welds that are smooth and free of spatter.

International Standards

| | |
|------------------------|----------------------|
| BS EN 1600:1997 | AWS A5.4 - 06 |
| E 29 9 L R 3 2 | E312-17 |

Typical All-weld Metal Analysis (wt%)

| C | Si | Mn | S | P | Cr | Ni | Mo |
|-------------|------------|------------|--------------|--------------|-------------|------------|------------|
| 0.10 | 1.0 | 0.6 | 0.012 | 0.015 | 29.0 | 9.5 | 0.5 |

Typical All-weld Metal Mechanical Properties

| Yield Strength N/mm² | Tensile Strength N/mm² | Elongation % | Hardness HB | Ferrite % |
|--|--|-------------------------|------------------------|------------------|
| >500 | 700- 850 | >20 | 240 | 30-40 |

Welding Positions

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| Flat butt welds, flat fillet welds and horizontal vertical fillet welds |
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Materials

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| All difficult to weld, high carbon steels and ferrous materials |
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Packaging

| Size mm | 2.5 x 300 | 3.2 x 350 | 4.0 x 350 |
|-----------------------|------------------|------------------|------------------|
| Pieces/Package | 135 | 73 | 48 |
| Pieces/Carton | 540 | 184 | 192 |
| Kg/Package | 2.5 | 2.5 | 2.5 |
| Packs/Carton | 4 | 4 | 4 |
| Kg/Carton | 10 | 10 | 10 |

Operating Requirements

| | | | |
|---------------------------|------------------|-------------------|--------------------|
| DC+ AC (70ocv min) | 50 – 80 A | 90 – 110 A | 120 – 150 A |
|---------------------------|------------------|-------------------|--------------------|

Additional Information

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|-----------------------------------|--|
| CE Certified | Constructional products directive (CPD) |
| Certification | BS EN 10204:2004 Type 2.2 |
| Material safety data sheet | MSDS 05 |
| Re-dry | 2 Hours @ 250°C if required |