

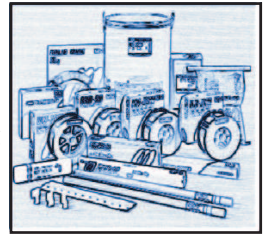
**Shielded Metal Arc Welding**

**ANU BOND - 312 (E 312- 16)** AWS A/ SFA 5.4,E312-16,IS:5206 -1983 E29.9 R16

**Stainless Steel Electrodes**

**Application :**

Suitable for welding of heavy machinery parts , earth moving equipments, automobile spring, trunnions of cement mill and other allied components, parts subject to corrosion and impact. Joining & surfacing of high Carbon, low and high alloy steel, tool steel, spring steel, case hardening steel, high speed steel, cost steel etc.



**Characteristics on Usage :**

A medium heavy coated rutile type all position electrode giving 30% Cr, and 10% Ni weld deposit. The electrode has very soft arc and gives smooth and defect free austeno ferritic weld meta.l Almost no distortions and embriblemnt of the based material. The weld metal is resistant to friction, heat and corrosion is work hardening and shockproof give radiography weld deposit.

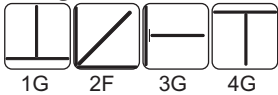
**Chemical composition of All-Weld metal (%) as per AWS**

| C        | Mn        | Si      | S         | P         | Cr        | Ni        | Mo       |
|----------|-----------|---------|-----------|-----------|-----------|-----------|----------|
| 0.15 Max | 0.50-2.50 | 1.0 Max | 0.030 Max | 0.040 Max | 28.0-32.0 | 8.0-10.50 | 0.75 Max |

**Mechanical properties of all-weld metal as per AWS**

| UT.S<br>(N/mm <sup>2</sup> ) | Elongation<br>( L=4d ) % |
|------------------------------|--------------------------|
| 660                          | 22                       |

**Welding Positions**



**Packaging & Welding Current**

| SIZE (mm)  | KG Per Packet | KG Per Carton | Current (Amps) | In Amps |
|------------|---------------|---------------|----------------|---------|
| 2.50 x 350 | 2             | 12            | AC / DC + Ve   | 50-70   |
| 3.15 x 350 | 2             | 12            |                | 70-100  |
| 4.00 x 350 | 2             | 12            |                | 100-130 |
| 5.00 x 350 | 2             | 12            |                | 130-160 |

