



Stainless Filler Wire

Dissimilar Steels

AWS A5.9: ER312
ISO 14343-A-2009 29 9

SW-312

DESCRIPTION & APPLICATION

Stainless Steel Filler Wire with a Duplex structure for the joining of dissimilar steels, low alloy steels to Stainless. Also used to provide a buffer layer on tooling prior to hard facing. Work Hardens to some degree. High resistance to impact. Can also be used for joining Wear Plates to mild steel support structures.

BASE MATERIALS

Mild and low alloy steels to stainless, tooling steels, such as D2, to provide isolating buffer layer prior to hard facing. Deposit can be used as a Wear facing, resistant to severe impact. Stainless Steel of a similar composition.

MECHANICAL PROPERTIES

700-850 UTS n/mm	>500 YIELD 0.2%	>20 ELONG A5%	~240 HARDNESS HB
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METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo
0.10	1.0	0.6	29.0	9.0	0.5

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

0.8, 1.0 and 1.2 mm (MIG)
1.6, 2.4 and 3.2mm (TIG)

WELDING INSTRUCTIONS

Maintain interpass temperature below 250°C. Pre-heat as per the base material requirements. Shielding Gas TIG, 100% Ar or Argon/Helium. MIG, Argon/Ox, Argon/CO₂ or proprietary gas mix.

For more details on welding of Stainless steel, please see our Information Sheets.
Visit: www.westbrookwelding.co.uk/downloads