



# Selectarc Inox 312HR

*Synthetic Electrode  
For difficult to weld steels*

## Classification

AWS A5.4 : ~ E312-26  
ISO 3581-A : E Z 26 9 R 7 3

DIN 8555 : E9-UM-250-KRZ

## Description & Applications

Synthetic electrode with high recovery (160%). With a rutile coating, for overlaying and welding high strength steels with each other and with stainless steels. Also recommended for buffer layers before hardfacing and to weld galvanised steels. Highly resistant against cracks. Offers soft fusion, very little spatters, self releasing slag.

### Base materials

**Low alloyed steels, carbon steels, galvanised steels, high strength steels.  
Stainless steels  
Tools steels  
Austenitic steels with Mn  
Screening steels  
Spring steels  
Armatures and wire lattice for reinforced concrete**

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Fe
0.06	1.1	1.0	26.5	9.5	0.2	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	Hardness
>550	>700	>25	Approx. 240 HB

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,0x300	2,5x350	3,2x350	4,0x450
Current	( A )	50-80	70-100	100-140	150-200

Redrying 1 hour at 300°C. Preheating of base materials with a high carbon equivalent to 100-250°C.

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= +	~ 50V
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