GeKa®

ELOX R 312

Standards :

TS 2716 EN 1600	:	E 29 9 R 12
EN 1600	:	E 29 9 R 12
AWS A5.4	:	~E 312-16

Chemical Composition of Weld Metal- % (Typical) :

C	Si	Mn	Ni	Cr
0.12	0.8	0.8	10.5	30.0

Mechanical Properties :

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20 °C)	Elongation ($L_o=5d_o$)(%)
min. 490	700-830	min.24 J	min. 20

Typical Base Material Grades :

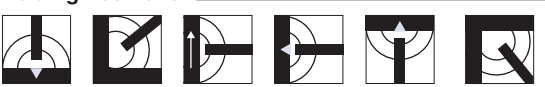
DIN :
X 7 Cr 13
X 7 Cr Al 13
X 10 Cr Al 13
X 8 Cr 17
X 20 Cr 13
X 15 Cr 13
X 22 Cr Ni 17
X 15 Cr Ni 13 4
X 8 Cr Ti 17
G-X 7 Cr 13
G-X 20 Cr 14
G-X 10 Cr Mo 13
G-X 8 Cr Ni 13

AISI :
403
405
410
420
430
430 Ti
431
446

Features and Applications :

* Alloyed-unalloyed high-resistant steels, Cr and Mn steels, joint welding of tool steels and different steels and repair welding of sprockets and wheelshaft. * Weld metal is resistant to corrosions, cracks and rust.
* Re-drying : 300 °C / min. 2 h

Welding Positions :



Current Type :

D.C.(+)
A.C.

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 250	3/32 x 10”	60-80	1260
3.20 x 300	1/8 x 12”	80-110	2475
3.20 x 350	1/8 x 14”	80-110	2925
4.00 x 350	5/32 x 14”	110-160	4370

Approvals :

TSE, CE, ABS