

### Typical applications

K-312T is formulated for MAG welding of 30%Cr-9%Ni stainless steels. It is used for joining dissimilar steels, steels with reduced weldability and buffer layers prior to hardfacing (rolls, forging dies, hotwork tools, dies for plastics and so on)

### Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② It has resistance to stress corrosion and highly insensitive to dilution and good scaling resistance up to 1150°C.
- ③ It also provides excellent usability with stable arc, less spatter levels, better bead appearance as the same as that of a solid MIG wire.
- ④ The shielding gas should be used 100%CO<sub>2</sub> for welding.
- ⑤ Refer to page 150 for more information on usage.

### Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Cr	Ni
CO <sub>2</sub>	0.04	0.83	1.00	30.2	9.5

### Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)
CO <sub>2</sub>	760 {77}	25

### Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	1.2	1.6	
Amp.	F	100~220A	160~260A
	H	100~240A	160~380A
	V	140~200A	180~240A

### Welding positions



Approved by

JIS