



STAINLESS STEEL WELDING ELECTRODES

RASI E 312-16

TECHNICAL SPECIFICATION SHEET



CHARACTERISTICS

RASI 312-16 is a Medium coated rutile type all position electrode giving the Weld Metal 30% chrome & 10% Nickel which has excellent Oxidation resistance and Radio graphic quality.

APPLICATIONS

RASI 312-16 is ideally suited for the high strength joints subject to service under wear, Impact, Heat and Corrosion. Some of the typical applications are Dissimilar Joints between Stainless Steel & High Carbon Steels. Difficult to weld steel eg. High carbon Hardenable tools, Die, and Spring Steel 13% Mn Steel and high Temperature Steels

CLASSIFICATIONS

AWS /SFA 5.4 E 312-16
IS : 5206 E-29.9R26

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.15%	Silicon - 0.3 - 0.9%
Manganese - 0.5 - 2.5%	Sulfur - 0.03%
Phosphorus - 0.03%	Cr - 28 - 32%
Ni - 8 - 11%	Mo - 0.8%

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (MPa) - 680 - 720
ELONGATION % - 22 Min.

WELDING CURRENT : AC, DC(±)

Ø 2.00 mm - 35 - 45 Amps
Ø 2.50 mm - 50 - 75 Amps
Ø 3.15 mm - 80 - 100 Amps
Ø 4.00 mm - 110 - 140 Amps

***FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :-
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storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

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