MIG 29/9

Old reference: MIG 312

Classification

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

Material N° : 1.4337

Description & Applications

Solid wire for joining of dissimilar steels with an austenitic-ferritic stainless steel deposit. Well adapted for steels difficult to weld as tool steels, Mn steels, spring steels… Metal deposit highly resistant to cracks, suitable for buffer layers before hardfacing and for building up cutting tools.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe	FN
0.1	0.45	1.8	30.2	9.3	0.15	0.1	<0.02	<0.02	Rem.	~38

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
520	730	25	+20°C 100

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8 1.0 1.2 1.6	100-150 120-200 140-220 180-260	22-27 24-28 24-28 24-30	Ar + 2%CO_2 Ar + 1%O_2 18-20 l/min

Ind.10