



TIG 29/9

Old reference: TIG 312

Classification

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

Material.N° : 1.4337

Description & Applications

Solid rod for TIG welding 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 |
|-----|-----|-----|------|-----|------|-----|-------|-------|------|
| 0.1 | 0.4 | 1.8 | 30.2 | 9.3 | 0.15 | 0.1 | <0.02 | <0.02 | Rem. |

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 | Shielding Gas |
|--------------|--|
| TIG = - | Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min |

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