

MIDALLOY MASTERCOR™ E312T0-1/4

CLASSIFICATION

- AWS 5.22 Class E312T0-1/4 / ASME SFA 5.22 Class E312T0-1/4 (UNS W31331)

DESCRIPTION

- MIDALLOY Mastercor™ E312T0-1/4 is a flux cored wire used to weld all type stainless steel, low alloy steel and high strength steel.
- MIDALLOY Mastercor™ E312T0-1/4 has excellent slag removal and runs with a spatter free globular transfer. The weld deposit has high ferrite (50% and greater) that makes this alloy great for hard to weld metals and dissimilar metal combinations.

APPLICATIONS

- This base material plate specification is listed under most ASTM A-240. There are many product forms that are covered under other ASME SA specifications (i.e. SA 240, A182, A276, etc.)
- MIDALLOY Mastercor™ E312T0-1/4 may be a better choice of filler metal for dissimilar metal combinations of carbon and low alloy steels to stainless steels. However, this is not good for high temperature applications (i.e. above 600°F).
- MIDALLOY Mastercor™ E312T0-1/4 is an excellent choice to weld high sulfur grades of stainless and low alloy steels.

TYPICAL CHEMISTRY

C	Cr	Ni	Mn	Si	P	S	Cu	Mo
0.13	29.0	9.0	1.2	0.5	.03	0.02	0.05	0.03

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	112,800 PSI
ELONGATION IN 2"	22%

RECOMMENDED WELDING PARAMETERS

DIAMETER	AMPERAGE	VOLTAGE	SHIELDING GAS
.045"	120-200	24-28	100% CO ₂ or 75%Ar-25%CO ₂
1/16"	150-280	28-33	100% CO ₂ or 75%Ar-25%CO ₂

STANDARD PACKAGING

- 25 lb. spool

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Office and Corporate Warehouse
 630 Axminister Drive
 Fenton, MO 63026 • 636-349-6000 • 800-776-3300
 Fax 636-349-2240

