

MIDALLOY CHROMAX E312-16 COATED ELECTRODE

CLASSIFICATION

- AWS 5.4 Class E312-16 / ASME SFA 5.4 Class E312-16

DESCRIPTION

- MIDALLOY CHROMAX 312 electrodes are used for welding wrought and cast alloys of similar composition, as well as for welding dissimilar metals.
- The weld deposits exhibit high tensile strength and offer good resistance to abrasion.

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Ni	S	P	Fe
0.12	1.80	0.56	29.3	9.4	.021	.022	BAL.

- Available sizes: 3/32" x 12", 1/8" x 14", 5/32" x 14" and 3/16" x 14"

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	108,000 PSI
YIELD STRENGTH	78,000 PSI
ELONGATION IN 2"	23%

TYPICAL ELECTRODE SIZES & CURRENTS FOR SMAW WELDING OF STAINLESS STEELS

DIAMETER	VOLTAGE	AMPERAGE	
		FLAT	VERTICAL & OVERHEAD
3/32"	24 – 28	70 – 85	65 – 75
1/8"	26 – 30	85 – 110	80 – 90
5/32"	28 – 32	110 – 140	100 – 120
3/16"	28 – 32	120 – 160	110 – 130

STANDARD PACKAGING

- 3/32" 8 lb. can / 48 lb. box
- 1/8" 10 lb. can / 60 lb. box
- 3/16" 10 lb. can / 60 lb. box
- 5/32" 10 lb. can / 60 lb. box

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