



## PRODUCT INFORMATION

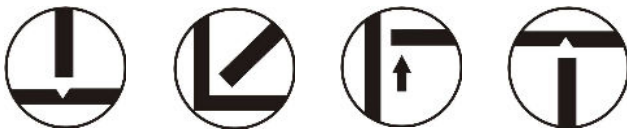
### SIFCHROME 312

EN ISO 1600 : E 29 9 R 32  
AWS A5.4 E312-17

## DESCRIPTION

A rutile coated high Cr/Ni electrode for welding difficult-to-weld steels like armour plate, austenitic Mn steel, high carbon steel and CR/Ni steels. SIFCHROME 312 produces a self-releasing slag with excellent weld appearance.

## WELDING POSITIONS



Suitable for use in fillet, downhand, vertical up and overhead positions.

## TYPICAL WELD METAL COMPOSITION

C	0.10
Cr	28.5
Mn	0.70
Ni	9.5
P	0.025
S	0.020
Si	1.20

## TYPICAL MECHANICAL PROPERTIES

Ult Tensile Strength	800 N/mm <sup>2</sup>
Yield Strength	650 N/mm <sup>2</sup>
Impact Values ISO-V	30J @ +20°C
Elongation	22%

## MATERIAL TO BE WELDED

Considered a problem solver for all kinds of steel grades including stainless and difficult to weld steels. Typical applications include joining hard manganese steels, tool steels, spring steels, buffering as well as joining dissimilar steel grades. Commonly used in the transport and lifting industry and repair and maintenance.

## AVAILABLE FORMATS

STAINLESS STEEL ELECTRODES		
Dia	4kg canister	Length
2.5mm	RC3122540	300mm
3.2mm	RC3123240	300mm
4.0mm	RC3124040	300mm

Current :

AC/DC =+

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email **service@weldability-sif.com**



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