

OK Tigrod 312

Bare corrosion resisting chromium-nickel welding rods for welding of materials of the 29% Cr, 9% Ni types. OK Tigrod 312 has a good oxidation resistance at high temperatures due to its high content of Cr. The alloy is widely used for joining dissimilar steels especially if one of the component is fully austenitic and steels that are difficult to weld, i.e. machine components, tools and austenitic manganese steels.

Specifications

Classifications	EN ISO 14343-A : W 29 9 SFA/AWS A5.9 : ER312
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Alloy Type	Ferritic-austenitic (29 % Cr - 9 % Ni)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	610 MPa	770 MPa	20 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	50 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu
0.10	1.6	0.4	8.8	30.7	0.20	0.14

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr
0.1	1.7	0.5	0.010	0.020	9	29