



FW 312

CODIFICATION: AWS :SFA 5.9 ER312

CHARACTERISTICS AND APPLICATIONS:

FW 312 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. The weld metal is highly resistant to crack and fissures. It is ideally suited for weld cast alloys of similar composition. The typical application include, welding dissimilar metals, unknown metals, leaf and coil springs, gear teeth, forged shafts, earth moving equipment and machine parts.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Ni
Percent	0.08	1.40	0.40	0.015	0.020	29.0	9.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d) %
720	22.0

SHIELDING GAS: Argon

CURRENT CONDITIONS: DCEN

WELDING POSITIONS: H, F, VU, OH

PACKING:

STANDARD SIZE: Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 1000 mm each.

QUANTITY 5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container.
Identification – AWS code is punched on each wire.