STARINOX 312

MMA Electrodes





STARINOX 312 is a rutile coated MMA electrode for joining difficult-to-weld steels, dissimilar steels and for wear-resistant surfacing and buffer layers.

Applications include repair and maintenance welding on machines, power transmission equipment and tools. The microstructure of the higher strength weld metal consists of ferritic-austenitic Cr-Ni steel, with $\sim 30\%$ delta-ferrite, and is highly crack resistant, rust-proof and non-scaling <1100°C.

Very good weldability, weld metal transfer is in fine droplets with easy slag removal, producing a good weld bead shape.

Classification				
EN ISO	3581-A: E Z (29 9) R 12			
AWS	A5.4:~E 312-16			

Approvals	
DB	
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CE	

Chemical analysis (Typical values in %)

	C	Mn	Si	Cr	Ni	Ferrite
All weld metal	0.08	1	1.2	28	12	25-50

All-weld metal Mechanical Properties

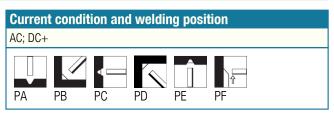
Heat Treatment	Yield Strength	Tensile Strength	Elongation	Impact Energy ISO - V (J)	Hardness	
noat moatmont	(N/mm²)	(N/mm²)	A5 (%)	+20 °C		
As Welded	≥ 450	≥ 650	≥ 20	≥ 30	220 HB	

Storage

Keep dry and avoid condensation.

Re-drying not generally required

If necessary: 250-300°C for 1 hour, 5 times max.



Packaging data

Diam.	Length	Current	Approx. weightn(kg/1000)	SMPA		VPMD	
(mm)	(mm)	(A)		PC	Code	PC	Code
2.5	300	55-75	18.3	28	W000288921	95	W000258738
3.2	350	75-115	36.37	15	W000288922	55	W000258739
4.0	350	90-140	54.1			35	W000258740

