STARINOX 312

MMA Electrodes

Stainless and Heat resistant steels

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 ~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
●

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 (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Impact Energy ISO - V (J) +20 °C	Hardness
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.

Current condition and welding position
AC; DC+

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	SMPA		VPMD	
				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