



Nexus 312

29%Cr 9%Ni - Stainless Steel electrode for MMA welding

Rutile Stainless Steel electrode for the joining of dissimilar steels, low alloy and Stainless steel to themselves and each other at maximum service temperature of 420°C. Producing butt welds and mitre finish fillet welds that are smooth and free of spatter.

International Standards

BS EN 1600:1997	AWS A5.4 - 06
E 29 9 L R 3 2	E312-17

Typical All-weld Metal Analysis (wt%)

C	Si	Mn	S	P	Cr	Ni	Mo
0.10	1.0	0.6	0.012	0.015	29.0	9.5	0.5

Typical All-weld Metal Mechanical Properties

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation %	Hardness HB	Ferrite %
>500	700- 850	>20	240	30-40

Welding Positions

Flat butt welds, flat fillet welds and horizontal vertical fillet welds
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Materials

All difficult to weld, high carbon steels and ferrous materials
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Packaging

Size mm	2.5 x 300	3.2 x 350	4.0 x 350
Pieces/Package	135	73	48
Pieces/Carton	540	184	192
Kg/Package	2.5	2.5	2.5
Packs/Carton	4	4	4
Kg/Carton	10	10	10

Operating Requirements

DC+ AC (70ocv min)	50 – 80 A	90 – 110 A	120 – 150 A
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Additional Information

CE Certified	Constructional products directive (CPD)
Certification	BS EN 10204:2004 Type 2.2
Material safety data sheet	MSDS 05
Re-dry	2 Hours @ 250°C if required