

Normalised designation : EN 14343-A : G 299 Equipment n° : 1.4337 AWSA5.9: ER312

Properties :

Very high-iron supply metal used for high-stress welding or for all heterogenic assemblages

Its high mechanical characteristics, its resistance to cracking, its good hold to oxidation and temperature, its ease of machining to the tool make it a universal working wire for the welding of all types of steels: steels deemed very difficult to weld or unknown shades, Mn steels (13%), high elastic limit steels, etc.

Applications :

Highly sought-after assemblies and hard-to-weld steel steel, HLE, moulded, jack rods... Sub-layer before hard reloading on crack-sensitive shades such as chromium carbides

Mechanical properties :

Re = 520 MPa

Rm = 730 MPa

A5 = 25 %

KV = 100 J à + 20°C

Parameters and conditions of use : MIG – Continuous current (+ up to electrode)

Gaz de protection	Ø (mm)	Paramètres de soudage	
		Arc pulsé (A)	(V)
Ar + 2%CO ₂ Ar + 1%O ₂ 18 - 20 L/min	1	120 - 200	24 - 28
	1,2	140 - 220	24 - 28
	1,6	180 - 260	24 - 30

Packaging : coil 15 kg

Responsibility: The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request