



WB312M/SW312 M.I.G. WELDING WIRE

Classifications	AWS A5.9-81 : ER312 BSEN12072-00 : G29 9 TUV								
Product Description	312 stainless steel, solid MIG wire.								
Applications	<p>WB312M is used mainly for welding and repairing steels of unknown specifications and for dissimilar welds between Ferritic and Austenitic steels. Also used for welding difficult to weld medium and high carbon steels, can also tolerate high rates of dilution.</p> <p>Typical grades include :- 709M40 (En19), 070M55, BS970 Part 1, 080M40 (En8), 070M55 (En9).</p> <p>Not recommended where PWHT is required or where materials will be subject to low temperature service.</p>								
Wire Composition(Weight %)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.	-	1.0	0.30	-	-	28.0	8.0	-	-
max.	0.15	2.5	0.65	0.03	0.03	32.0	10.5	0.5	0.50
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		650 min.				
	Yield Stress/0.2% Proof Stress		N/mm ²		450 min.				
	Elongation on 5D		%		15 min.				
	Impact Energy CV @ as-welded		Joules		-				

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	300	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	22	26	29	-	-
Packaging Information								
Kg Per Reel		-	15	15	15	15	-	-
Storage	Storage It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
Gases	Gas Pure Argon or Argon + 2%O ₂ mixture Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

