

TECH-ROD 312

- I. **DESCRIPTION:** Tech-Rod 312 electrodes are used for welding wrought and cast alloys of similar composition as well as for welding of dissimilar metals. The weld deposits exhibit high tensile strength and offer good resistance to abrasion.
- II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.4 Class E312-16.

III. **CHEMICAL COMPOSITION**

Carbon	.12
Manganese	1.80
Silicon	.56
Chromium	29.3
Nickel	9.4
Sulfur	.021
Phosphorus	.022
Iron	Balance

MECHANICAL PROPERTIES

Tensile Strength	
109,000 PSI	750 MPA
Yield Strength	
78,000 PSI	540 MPA
Elongation	23%

IV. **WELDING PARAMETERS**

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. **PACKAGES AVAILABLE:**

3/16"-10# can, 5/32"-10# can, 1/8"-10# Can, 3/32"-8# can