

## Core wire alloyed High Chrome – Nickel Austenite.

# STARBLAZE PRIME 312

### Classification

**AWS A5.4 : E 312-16**

**DIN EN ISO 3581-A : E 29 9 R 12**

### Description and applications

High-alloyed Rutile-basic coated versatile electrode with approx 40% ferrite for dissimilar joining and repair welding. The ferritic-austenitic weld metal is stainless and corrosion resistant. Used for joining high strength joint welding, difficult to weld steels, tempered and tool steels, die and spring steels, dissimilar steels, cast steels, buffer layers prior to hardfacing etc. Superior weldability for all steels. Soft fusion, without spatters, self-releasing slag, smooth weld bead, very easy striking and re-striking. Packed in vacuum pack system.

### Typical Weld Metal Chemical Composition(%)

C	Si	Mn	Cr	Ni	S	P
0.10	0.90	1.0	29.0	9.50	0.010	0.015

### All weld metal Mechanical Properties (Typical)

Yield strength $R_p(N/mm^2)$	Tensile strength $R_m(N/mm^2)$	Elongation $A_5 (%)$
$\geq 500$	$\geq 800$	$\geq 20$

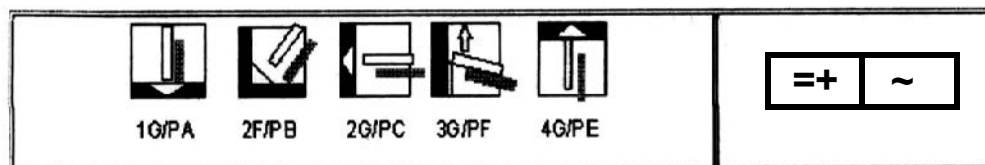
### Amperes (A)

2.50mm	3.15mm	4.00mm	5.00mm
50-80	70-110	100-150	140-190

### Welding instruction

Pre-heating depending on base material, low heat input required. Otherwise pre-heating not necessary. Interpass temperature max. 200 °C.  
Redry electrode at 300 - 350°C for 1-2 hr. if necessary.

### Welding Position



## Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

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