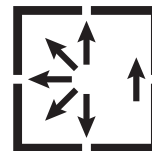


## HYPERARC™ 312L

### 312L STAINLESS STEEL ELECTRODE



#### SUMMARY

- ✓ Excellent arc stability
- ✓ High penetration
- ✓ Less spatter
- ✓ Concentrated arc

#### CLASSIFICATION

- ✓ AS/NZS 4854: ES312L-16
- ✓ AWS/ASME SFA5.4: E312-16

#### DESCRIPTION

The HYPERARC Dissimilar Metals 312L is a Stainless Steel electrode used for welding dissimilar or steels of unknown composition.

#### RECOMMENDED CURRENT

AC & DC+

#### OPERATING DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	CURRENT RANGE
2.6mm	300mm	60-80A
3.2mm	350mm	75-115A

#### TYPICAL CHEMICAL COMPOSITION (%)

C	Mn	Si	P	S
0.092	0.915	0.849	0.025	0.037
Ni	Cr	Mo	Cu	
9.9	29	0.052	0.2	



#### TYPICAL MECHANICAL ANALYSIS

Yield Stress	655 MPa
Tensile Strength	750 MPa
Elongation	23%

#### TYPICAL APPLICATIONS

- ✓ Welding mild steels to stainless steels
- ✓ Used for buffering prior to hard facing
- ✓ Repairs and Maintenance

#### PACKAGING INFO

ELECTRODE SIZE (MM)	WEIGHT (KG)	SKU
2.6mm	1kg (Handy Pack)	U63017
2.6mm	2kg (Vacuum Seal)	U63019
3.2mm	1kg (Handy Pack)	U63018
3.2mm	2kg (Vacuum Seal)	U63020