

# TL 312

**International Standards:**

AWS SFA 5.4 : E 312-16  
 JIS Z 3221 : D 312-16  
 DIN 8556 : E 29 9 R 12

**Applications and Properties :**

The weld metal of TL 312 is a stainless steel which contain more quantities of ferrite than TL 309 / TL 309L. Crack resistance is good. It is excellent for the welding of dissimilar metals, cladding steel and steels with high hardenability.

**Aplikasi dan Penggunaan :**

Hasil pengelasan TL 312 memiliki kandungan ferrite lebih tinggi dari TL 309 / TL 309L. Ketahanannya terhadap keretakan sangat baik. Sangat cocok untuk pengelasan baja yang berbeda jenisnya, baja yang tidak diketahui jenisnya, dan baja yang memiliki kekerasan yang tinggi.

**Typical Chemical Analysis of Deposited Metal (%) :**

| C    | Mn   | Si   | Cr    | Ni   | P     | S     |
|------|------|------|-------|------|-------|-------|
| 0,12 | 1,35 | 0,50 | 28,50 | 8,95 | 0,015 | 0,010 |

**Typical Mechanical Properties of Deposited Metal :**

| Yield Strength (N/mm <sup>2</sup> ) | Tensile Strength (N/mm <sup>2</sup> ) | Elongation (%) | Impact Value (Joule) |
|-------------------------------------|---------------------------------------|----------------|----------------------|
| -                                   | 760                                   | 29             | -                    |

**Size & Recommended Current Range (DC or AC) :**

| Size (mm)             | 2,6 x 300 | 3,2 x 350 | 4,0 x 350 |
|-----------------------|-----------|-----------|-----------|
| Amperages (Amp)       | 50 - 85   | 80 - 120  | 100 - 150 |
| Weight / pack (kgs)   | 4,5       | 5         | 5         |
| Weight / carton (kgs) | 18        | 20        | 20        |

**Welding Positions :**

**Attention!**  
 Redrying: 200°C/2h



**SYMBOL OF QUALITY**

**Manufactured by:**

**PT. Lion Superior Electrodes**

Jl. Raya Bekasi Km. 24,5 (Cakung), Jakarta 13910 - Indonesia

Telp: 021-4600779, 4600784, Fax: 021-4600785

email: Marketing@lionweld.com, Lse@lionweld.com