

# OK Tigrod 312

GTAW  
ER312

## Description

Bare, corrosion-resistant, chromium-nickel welding rods for welding materials of the 29% Cr, 9% Ni types. OK Tigrod 312 has good oxidation resistance at high temperatures due to its high content of Cr. The alloy is widely used for joining dissimilar steels, especially if one of the components is fully austenitic, and for steels that are difficult to weld, i.e. machine components, tools and austenitic-manganese steels.

## Welding current

DC(-)

## Classifications

SFA/AWS A5.9	ER312
EN 12072	W 29 9

## Wire composition

C	Si	Mn	Cr	Ni	Mo	Cu
<0.15	0.5	1.8	30.5	9.5	<0.3	<0.3

## Typical mech. properties all weld metal

Yield stress, MPa	610
Tensile strength, MPa	770
Elongation, %	20

## Charpy V

Test temps, °C	Impact values, J
+20	50

## Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0