

Super6 312

Features and Applications

- A 29 – 9 stainless steel suitable for joining difficult to weld steels such as tool and spring steel. Also for dissimilar materials and has a high resistance to weld metal cracking
- Repairs to tool/spring/manganese/high speed and cast steels Recommended for repairs to dies and moulds

Standards

AWS : 5.9 ER 312
EN ISO 14343 : 29 9
BS 2901 312 S94

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	750
Hardness BHN	200

Chemical Composition

C	Si	Mn	Ni	Cr	Mo
0.10	0.40	1.70	9.00	30.0	0.10

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Spool 15.0kg Spool

Diameter	Part No.	Diameter	Part No.
0.8mm	7208	0.8mm	7210
1.0mm	7209	1.0mm	7211

Super6 316 LSI

Features and Applications

- A molybdenum bearing stainless steel with low carbon content. It is corrosion resistant for welding molybdenum bearing austenitic stainless steel
- Power generation, chemical, food industries

Standards

AWS : 5.9 ER 316 LSI
EN ISO 14343 : 19 12 3 LSI
BS 2901 316 S93

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	650
Hardness BHN	180

Chemical Composition

C	Si	Mn	Ni	Cr	Mo
0.02	0.80	1.50	12.0	19.0	2.00

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

0.7kg Spool 5.0kg Spool 15.0kg Spool

Diameter	Part No.	Diameter	Part No.	Diameter	Part No.
0.6mm	7198	0.6mm	7201	0.6mm*	7204
0.8mm	7199	0.8mm	7202	0.8mm	7205
1.0mm	7200	1.0mm	7203	1.0mm	7206
				1.2mm	7207

*Supplied on 12.5kg spool