

AMERIARC

Ameri 312 A1 (Gold)

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 312-17*

EN 1600: E 29.9 R 32

DIN 8556: E 29.9 R 23

ISO 3581: E 29.9 R 32

DESCRIPTION & APPLICATION:

Ameri 312 A1 is the ultimate electrode for welding all types of steels. It is high resistance to cracking coupled with good wear, heat, impact & corrosion resistance. The electrode for joint welding at high tensile unalloyed steels tempered and tool steels, high-manganese steels and joints between dissimilar steels with high alloyed stainless steels.

A wide range of applications for repairing tools dies, spring steels & any dissimilar metal combinations. It also recommended for repairing worn parts, as an underlay for hardfacing & gear wheel shafts.

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

Cu	C	Mn	Cr	Si	S	Ni	P	Mo	Fe
.06	.1	.8	29	1	.01	9	.02	.7	Bal

Flux Color : GOLD

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile strength as welded	128,000 psi (880 MPa)
Work hardened	186,000 psi (1282 MPa)
Elongation	32%
Hardness	230HB

WELDING CURRENT & INSTRUCTIONS:

Recommended Current : DC reverse polarity (Electrode +) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	35	60	75
Maximum Amperage	70	110	140

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	2.5	3.25	4.0
	Length (mm)	12" (300)	14" (350)	14" (350)
Packaging	Electrodes /lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0