Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1960 - 2010

D&H 312

CODIFICATION : AWS : SFA 5.4 E312-16

CHARACTERISTICS AND APPLICATIONS:

D&H 312 is a rutile type electrode which can be considered as outstanding by virtue of its excellent performance, characteristics and weld metal of controlled chemical composition. The weld metal is highly resistant to crack and fissures. These electrodes were designed to weld cast alloys of similar composition. The typical application include, welding dissimilar metals, unknown metals, leaf and coil springs, gear teeth, forged shafts, earth moving equipment and machine parts.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	Cr	Ni	S	P
Percent	0.08	1.40	0.55	28.8	10.10	0.012	0.025

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L=4d) %
832	22.0

CURRENT & PACKING DATA: AC / DC(+)

Size (mm) Dia x Length	:	5 x 350	4 x 350	3.15 x 350	2.5 x 350
Current Range (Amps)	:	150-180	110-140	80-100	60-80
Weight / Carton (kgs)	:	2.5	2.5	2.5	2.5

APPROVALS: Ordnance Factory

PRECAUTIONS:

1. Re-dry the electrodes at 250-300°C for one hour for best results.
2. Use low current short arc and minimum weaving.