

# EZ - KROM 8

## CLASSIFICATION

EN ISO 3581-A	AWS / ASME SFA-5.4
E 29 9 R 12	E312-16

## DESCRIPTION AND APPLICATION

A rutile coated electrode for welding of austenitic-ferritic steels, similar corrosion resisting steels and steel cast. Electrode is also suitable for joining dissimilar steels (alloyed and unalloyed), hard manganese steels, steels with poor weldability and high strength steels. Suitable for wear resistant surfacing and for buffer layers at hardfacing. Weld metal has an austenitic-ferritic structure.

## MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R <sub>p0.2</sub> N/mm <sup>2</sup>	R <sub>m</sub> N/mm <sup>2</sup>	A <sub>5</sub> %	Tvrdoća HB
> 490	700 - 830	> 20	235 - 270

## APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

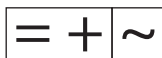
	C	Mn	Si	Cr	Ni
%	0,15	1,0	1,2	29,0	9,0

## RECOMMENDED WELDING CURRENT

Ø mm	2,5	3,2	4,0	5,0
A	60 - 80	80 - 100	110 - 130	140 - 170

## PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,5 x 300	52 800	1,1
Ø 3,2 x 350	26 300	1,1
Ø 4,0 x 350	18 200	1,2
Ø 5,0 x 450	9 100	5,0



Marking: **E 312-16**  
Dry before use 2h/300°C