

BCM Electrodeal 312

A versatile electrode for high strength and extreme crack resistance to all steel.

The BCM Electrodeal 312 offers a ferritic-austenitic duplex weld metal with remarkable versatility. Its high alloy stainless electrode has an estimated ferrite content of FN 40. The welded metal is extremely insensitive to dilution by melted parent metal and resistant to stress and corrosion attack. Other remarkable properties include a soft and smooth arc, exceptional durability and resistance to cracking, and a work-hardening deposit. It is easy to operate at low currents and in all position.

Chemical Composition (%)	Mechanical Properties
Alloy Basis: Cr, Ni, Mn	UTS- 75-85 kgf/mm ² , Elongation - 22-26%.

TYPICAL APPLICATIONS

Parts of heavy machinery, earthmoving equipment, vehicle springs, cement mill parts, and components exposed to impact, heat, and corrosion. joining and surfacing of steels that are high carbon, low and high alloy, tool steel, spring steel, manganese steel, high speed steel, cast steel, hard to weld steel, and unknown steel.

CURRENT RANGE & PACKING DATA

Size(mm)	Length(mm)	Current (amps)	Weight of packet in kgs	Weight of carton in kgs
5.00	350	140 - 180	2	10
4.00	350	90 - 140	2	10
3.15	350	70 - 110	2	10
2.50	350	50 - 80	2	10

PACKING: Electrodes are packed in 2 kg plastic packets and 5 of these are shrink wrapped in a cardboard box.

WELDING PROCEDURE:

After properly cleaning the weld region, prepare the joint edges. High alloy and high carbon steel should be heated to between 200 and 250°C. After welding, they should be slowly cooled. Use stringer beading and maintain a short arc. It is recommended to hot peen joints.