

# TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

## GF312

Applicable Specification  
JIS Z 3323 TS312-FB0  
AWS A5.22 E312T0-1/4

### ● Applications and Characteristics

TASETO GF312 contains a higher amount of ferrite than Type 309 all weld metal. It is suited for dissimilar metal joint and overlay welding of carbon steel with containing a higher amount of carbon or nickel. Because of high ferrite content, post weld heat treatment can result in embrittlement.

### ● Notes on Usage

\* Please refer "Guideline for Welding Stainless Steel with GF3 Wires".

### ● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.110	0.48	1.39	0.025	0.002	8.99	28.60	0.01	0.02

### ● Ferrite Content of All Weld Metal

\* Typical Ferrite Content: >20% (Schaeffler's Diagram)  
>18FN (DeLong's Diagram)  
36% (Ferrite Scope)

### ● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	565	714	23.0

### ● Sizes Available and Shielding Gas

Size (mm)	Shielding Gas
1.2	CO <sub>2</sub> or Ar+20%CO <sub>2</sub> , 20L/min