

CIGWELD

AN ESAB BRAND

BLUESTRIKE

BLUESTRIKE 312

PRODUCT DATA SHEET



BLUESTRIKE ELECTRODE HANDY-PACKS FOR ALL OF YOUR SMALLER PROJECTS



AC
DC+

45
OCV

STAINLESS STEEL

MILD STEEL

BLUESTRIKE 312:

BlueStrike 312 is a highly alloyed stainless steel electrode that is extremely resistant to cracking. 312 has a host of features which make it suitable for the welding of all types of steels.

BlueStrike 312 has easy arc starting and excellent stability on low Open Circuit Voltage (O.C.V) welding machines.

BlueStrike 312 has a rutile type flux coating gives smooth, stable running in all positions (except vertical down) especially on low current settings.

BlueStrike 312 Weld deposit gives excellent resistance to corrosion and oxidation. BlueStrike 312 is recommended for the repair and maintenance of all steels, particularly those of unknown composition. It is suitable for:

- Joining dissimilar steels, such as stainless steel to carbon steel.
- Repairing die or tool steels.
- Use as a protective overlay against corrosion.
- Use as an intermediate or buffer layer prior to hard surfacing.

FEATURES:

- Easy-to-Use Rutile Type, High Alloy Electrode
- Outstanding Operator Appeal!
- WELDS ALL Steels!
- Ideal for Repair & Maintenance Jobs
- Easy Arc Starting and Excellent Stability on Low O.C.V. Welding Machines
- Not Recommended for Welding Cast Irons

CLASSIFICATIONS:

AS/NZS 4854:	B ES312-16
AWS/ASME-SFA A5.4:	E312-16

SPECIFICATIONS:

Diameter (mm)	Current Range (amps)	
	MIN	MAX
2.5	40	80
3.2	75	110

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

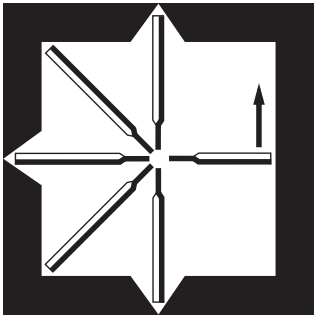
Yield Strength	630 MPa
Tensile Strength	780 MPa
Elongation	25%
CVN Impact Values	30 J av @ +20°C

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.11%	Mn: 0.60%	Si: 0.88%	Cr: 28.4%
Ni: 9.10%	S: 0.011%	P: 0.020%	

WELDING POSITIONS:

All positional - except vertical down welding



ORDERING INFO:

PART NO.	SIZE PACK	SIZE	CARTON
WEW0225	BlueStrike 312 Electrodes 2.5mm	10 rods	20 x 10 rods
WEW1025	BlueStrike 312 Electrodes 2.5mm	1kg	12kg - 12 x 1kg
WEW0232	BlueStrike 312 Electrodes 3.2mm	10 rods	20 x 10 rods
WEW1032	BlueStrike 312 Electrodes 3.2mm	1kg	12kg - 12 x 1kg