

Thermanit 30/10

GMAW wire

Classifications	EN 12072	AWS A 5.9	Mat. No.
	G 29 9	ER312	1.4337

Characteristics and field of use Stainless; wet corrosion up to 300 °C (572 °F). High resistance to hot cracking: good toughness at high yield strength. For joining and surfacing applications with matching/similar steels/cast steel grades. For fabricating tough joints on unalloyed/low-alloy structural steels of higher strength, on high manganese steel and CrNiMn steels, between dissimilar metals e.g. between stainless or heat resistant and unalloyed/low-alloy steels/cast steel grades.

Materials X10Cr13 (1.4006), X120Mn12 (1.3401), S235J, S355J

Typical analysis in %	C	Si	Mn	Cr	Ni
	0.15	0.5	1.6	30.0	9.0

Mechanical properties of the weld metal according to EN 1597-1 (min. values at RT)	Heat-treatment	Yield strength 0.2% N/mm ²	Tensile strength N/mm ²	Elongation (L ₀ =5d ₀) %	Impact values in J CVN
	AW	500	750	20	27

Structure Austenite/ferrite

Welding instruction

Materials	Preheating	Postweld treatment
Stainless and heat resistant, unalloyed and low-alloy steels/cast steel grades; combinations	According to parent metal	Mostly not necessary

Polarity = +
Shielding gas (EN 439) M12, M13

Packaging and weights	Diam. (mm)	Spool	kg / pack
	1.0	B300	15
	1.2	B300	15