

29.9 SUPER R (Limarosta® 312)

Key Features

- Acid rutile high CrNi-alloyed all position electrode
- Excellent weldability and self releasing slag
- Weldable on AC and DC+ polarity

Typical Applications

- Excellent for repair welding
- Tool steels, Shafts, Gear teeth, Free cutting steels
- Dissimilar alloy combinations

Conformances

AWS A5.4: E312-17* (*closest)

AS/NZS 4854-A: E 29 9 R 12

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	299SR-25-1	CAN 4.2 kg (3 x CAN per carton)
2.5	350	299SR-25LP-1	Linc Pack 1.0kg
3.2	350	299SR-32-1	CAN 4.2 kg (3 x CAN per carton)
3.2	350	299SR-32LP-1	Linc Pack 1.0kg
4.0	350	299SR-40-1	CAN 4.4 kg (3 x CAN per carton)

Mechanical Properties - As required per AWS A5.4 & AS/NZS 4854-A

	Yield Strength MPa	Tensile Strength MPa	Elongation %
Requirements - AWS	-	660 min	22 min*
Requirements - AS/NZS	450 min	650 min	15 min
Typical Results - As Welded	700	830	25

*Minimum elongation required by AWS not always obtained

Deposit Composition

	%C	%Mn	%Si	%Ni	%Cr
Typical Results - As Welded	0.1	0.8	1	9.5	29

Typical Operation Procedures

Polarity	Current (amps)		
	2.5mm	3.2mm	4.0mm
AC / DC±	60-90	75-120	100-155