

ROWELD 318

FERRITE CONTROLLED, LOW CARBON, 18/13/2.3 MO
WITH NB STAINLESS STEEL ELECTRODE.

BASIC ALLOY: FE, CR, NI, MO, NB
AWS/SFA-5.4: E 318-17
EN ISO 3581-A E 19 12 3 NBR 32

KEY FEATURES:

A ferrite controlled, low carbon, 18/13/2.3 Mo with Nb electrode. Weld deposit is resistant to inter granular corrosion cracking, resistant to pitting. The electrode gives smooth arc, fine and rippled bead appearance and easy slag detachability

APPLICATIONS

- Suitable to weld Niobium and Titanium based stainless steels.
- Maximum resistance to cracking, corrosion and scaling.
- Stabilized with Niobium to resist intergranular corrosion between 425°C and 845°C

RE-DRY CONDITION:

- -Dry the electrode at 300°C for 1 hrs. before use

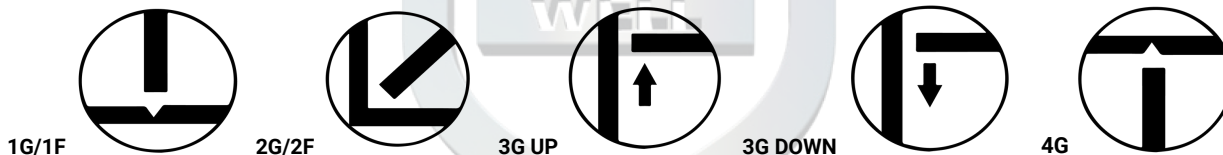
CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Cr	Ni	Mo	Nb
0.08 max.	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	17.00-20.00	11.00-14.00	2.00-3.00	6XC min.-1.00 max

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @	FERRITE (FN)
450 Min.	550 min.	25-40	+27C : 80-120 J	5-9

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+ / AC) Amps	Kg/pkt.	Kg/Case
2.50 / 2.40	3 / 32"	60-80	2	10
3.15 / 3.20	1 / 8"	80-100	2	10
4.00	5 / 32"	110-140	2	10
5.00	3 / 16"	140-170	2	10