



SS 318

STAINLESS STEEL ELECTRODE

CLASSIFICATION :

IS : 5206-83 : E 19.12.2NbR26
AWS/A 5.4 : E 318-16

CHARACTERISTICS :

A rutile type stainless steel electrode designed for welding of AISI 318 grade and similar composition steels. Columbium in the weld metal provides resistance to intergranular carbide precipitation, thus increasing resistance to intergranular corrosion. Weld metal has excellent creep strength at elevated temperature upto 850°C. Electrodes operate equally good on AC as well as DC(+) in all conventional positions.

APPLICATIONS :

* Joining & Surfacing of AISI 316, 318, 316 Ti and similar composition steels.
Useful in chemical industries, where various types of corrosive media are handled.

RECOMMENDATIONS :

Re-dry the electrodes at 200°C for one hour. Use low current and short arc stringer bead technique and maintain interpass temperature at 150°C max.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	Cr	Ni	Mo	Cb	S	P	Cu
0.08	0.5-2.5	1.0	17-20	11-14	2-3	0.2-1.0	0.03	0.04	0.75
max		max					max	max	max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :

Ultimate Tensile Strength	Elongation (GL=4d) (%)	CVN Impact Value at 27°C
N/mm ²		Joules
550 min	25 min	70 min

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180

SPECIAL CHARACTERISTICS :

DELTA FERRITE : 5 to 10 FN

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