

# SUPRANOX RS 318

## TOP FEATURES

- Good striking and restriking.
- The weld metal transfer is in fine droplets, nearly spatter free with a generally self-releasing slag
- Finely rippled concave fillet welds with an outstanding weld bead aspect.

## CLASSIFICATION

AWS A5.4 E318-16  
EN ISO 3581-A E 19 12 3 Nb R 12

## CURRENT TYPE

AC, DC+

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

TÜV	DB
+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	Mo	Nb	Ferrite
≤0.03	0.8	0.9	19	11.5	2.7	0.4	5-15

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.4	AW	not specified	≥550	≥25	not specified
EN ISO 3581-A	AW	≥350	≥550	≥25	not specified
Typical values	AW	400	600	30	50

\* AW = As welded

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.0 x 300	40-55
3.2 x 350	75-105
4.0 x 350	100-130

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	95	1.8	W100258422
3.2 x 350	VPMD	56	2.0	W100258423
4.0 x 350	VPMD	40	2.2	W100258424

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
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