

AROSTA 318

MMA (SMAW)

RUTILE BASIC ALL POSITION STAINLESS STEEL ELECTRODES FOR WELDING Ti OR Nb STABILIZED

PRODUCT DESCRIPTION

Rutile basic all position stainless steel electrodes for welding Ti or Nb stabilized 316 or equivalent steels
 High resistance to general and intergranular corrosion
 Smooth bead appearance
 Easy slag release
 Strong electrode coating
 Weldable on AC and DC

CLASSIFICATIONS

AWS A5.4M E318-16
 ISO 3581 E 19 12 3 Nb R 1 2
 APPROVALS TÜV

ASME IX QUALIFICATION

QW432 F-No 5
 QW442 A-No 8
 Mat-Nr 1.4576

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G



PH/5Gu

CURRENT TYPE

AC / DC + / -

TEMPERATURE RANGE

Pressurized parts -60...+400°C
 Oxidation resistance n.a

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	Cr	Ni	Mo	Nb	FN
Min.	--	--	--	17.0	10.0	2.5	--	3
Max.	0.08	2.0	1.2	20.0	13.0	3.0	--	10
Typical	0.03	0.8	0.85	18.0	11.5	2.7	0.35	6-12

ALL-WELD MECHANICAL PROPERTIES

As welded	AWS A5.4	ISO 3581-A	Typical
Tensile strength (MPa)	min. 550	min. 550	630
0.2% proof strength (MPa)	--	min. 350	500
Elongation (%)	25	25	38
Impact ISO-V(J) +20°C	--	--	60
-20°C	--	--	50
-196°C	--	--	35

TYPICAL OPERATING PARAMETERS

Diameter (mm)	2.5	3.2	4.0
min. A	50	60	80
max. A	70	90	120

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				pack	box	pack	box
CARDBOARD BOX	2.5	350	532043	135	675	2.8	14.5
	3.2	350	532234	140	420	5.0	15.6
	4.0	350	532340	90	180	4.8	14.9

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.