



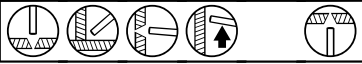
Cromarod 318

SMAW - (Stick) - MMA
Stainless Steel

Date:	2013-10-21
Revision:	23

Description:

Cromarod 318 is a niobium stabilised, rutile flux coated electrode designed for welding Nb or Ti stabilised 18% Cr / 12% Ni / 3% Mo austenitic stainless steels type 318. The electrode has good positional characteristics and produces low spatter levels and good slag detachability. Cromarod 318 is primarily intended for service temperatures above 400 °C and can also be used for 316 material grades used at elevated temperatures.

Welding positions:**Coating type:**

Rutile

Welding current:

DC+, AC OCV > 39V

Ferrite content:

FN 5 (WRC-92)

Corrosion resistance

Good resistance to general and intergranular corrosion in dilute hot acids.
Good resistance to oxidation and corrosion at elevated temperatures.

Scaling temperature:

Approx. 850 °C in air.

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			17,0	10,0
Typical	0,02	0,9	0,7	0,02	0,02	18,0	12,0
Max	0,08	1,0	2,0	0,025	0,025	20,0	13,0

	Mo	Cu	V	Nb
Min	2,5			10xC
Typical	2,7			0,4
Max	3,0	0,5	0,1	1,0

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	480 MPa
Tensile Strength, Rm:	≥ 560 MPa	600 MPa
Elongation, A5	≥ 25%	30%
Impact energy, CV:		20 °C • 70 J

Classification:

AWS A5.4
ISO 3581-A

E 318-17
E 19 12 3 Nb R 12

Approvals:

CE

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	300	74462500	50-80	21	0,61	90	1,0	36
3,2	350	74463200	80-120	22	0,63	46	1,4	51
4,0	350	74464000	130-170	22	0,63	30	1,8	60
5,0	450	74465000	160-220	22	0,65	14	2,8	25