

ES 318-17

Type Acid-rutile

SMAW

E318-17

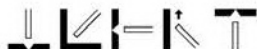
ESWECO
The Art of Welding

Description

ES 318-17 is a stainless LMA electrode for welding Nb- or Ti-stabilised stainless steels of the 18Cr12Ni2-3Mo type. ES 318-17 is specially designed for welding Nb- and Ti-stabilised stainless steel corresponding to DIN Werkstoff Nr: 4573 and 4583.

Current

DC+, AC OCV 50 V



Classifications

EN 1600	E 19 12 3 Nb R 3 2
SFA/AWS A5.4	E318-17
Werkstoff Nr.	1.4576

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Cu
<0.03	0.7	0.9	18.0	12.0	2.8	<0.6	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	620
Elongation A5, %	35

Charpy V

Test temps, °C	Impact values, J
+20	55

Ferrite content FN 6-12

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	60-90	30
3.2	350	80-120	32
4.0	350	120-170	33