Stanvac® INTERNATIONAL

Product Data Sheet

Stainless steel Rutile electrode

STAVINOX 318

Classification: **AWS A5.4 :** E 318 - 16 **DIN 8556:** E 19 12 3 Nb R 23

DIN EN 1600 : E 19 12 3 Nb R 32 **Werkstoff Nr:** 1.4576

Description and Applications:

Rutile-basic MMA Electrode for Welding Stabilized austenitic, chemical resistant Cr-Ni-Mo steels at working temperatures upto 400° C, for corrosion resistant Cr-steel, also for alloy like claddings. Good fusion of joint faces, without spatters, fenely rippled bead surface, very easy slag removal, easy striking and restriking.

Base Materials:

Material No.	Steel	Material No.	Steel
1.4401	X5 CrNiMo 17 12 2	1.4429	X2 CrNiMoN 17 13 3
1.4404	X2 CrNiMo 17 13 2	1.4571	X6 CrNiMoTi 17 12 2
1.4406	X2 CrNiMoN 17 12 2	1.4573	X10 CrNiMoTi 18 12
1.4408	G-X6 CrNiMo 18 10	1.4580	X6 CrNiMoNb 17 12 2
1.4410	X10 CrNiMo 18 9	1.4581	GX5 CrNiMoNb 19 10
1.4417	X2 CrNiMoSi 19 5	1.4583	X10 CrNiMoNb 18 12

Weld Metal composition (Typical Weight %):

C	Mn	Si	S	P	Cr	Ni	Mo	Nb	*Ferrite*
0.03	0.80	0.90	0.009	0.015	19.00	12.00	2.45	0.45	Austenite with Approx. 8% Ferrite

All weld metal Mechanical properties (typical)

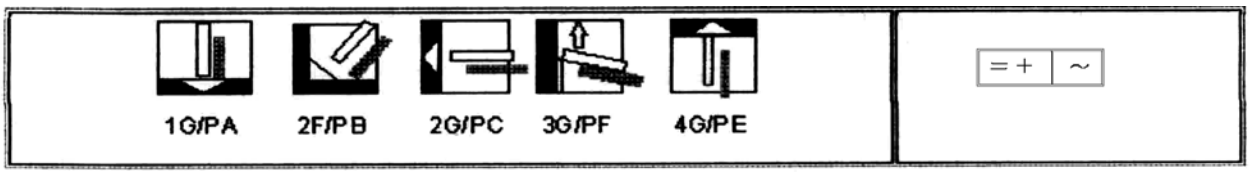
Yield strength R_p 0,2 %N/mm^2	Tensile strength R_m N/mm^2	Elongation A_5 %	Charpy Impact value ISO-V J + 20°C
450	590	35	65

Amperes (A)

2.50	**3.15**	**4.00**	**5.00**
50-80	**80-110**	**110-150**	**150-180**

Welding Instruction:

Keep dry and avoid condensation. Re-dry not generally required. If necessary; 300-350° C for 1 hour 5 times max.



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