

EI 318

Coated Electrode for Stainless Steels -

Standards	
AWS/ASME SFA - 5.4	E318-16
EN ISO 3581 - A	E 19 12 3 Nb R 32
TS EN ISO 3581 - A	E 19 12 3 Nb R 32
DIN M. No.	1.4576

Properties and Applications

Rutile type stainless steel electrode for welding stabilized Cr-Ni-Mo austenitic stainless and cast steels. Suitable for using operating temperatures up to 400°C. Especially used for welding of stainless steels acid, salt and alkaline tanks, valves and pipes in chemical, textile, paint and paper industries. Possible to use equally well both with AC and DC. Easy arc striking and re-striking. Fine-droplet metal transfer, good wash-in of joint sides, easily removable slag.

Approvals & Certificates

TSE TUV CE

Materials

EN	Material	ASTM
X5CrNiMo17-12-2	1.4401	316
GX5CrNiMo19-11-2	1.4408	CF-8M
X2CrNiMoN17-13-3	1.4429	316LN
X3CrNiMoN17-13-3	1.4436	316
X6CrNiMoTi17-12-2	1.4571	316 Ti
X6CrNiMoNb17-12-2	1.4580	316 Cb
G-X5CrNiMoNb19-11-2	1.4581	
	1.4583	318
GX3CrNiMoCuN24 6 5	1.4573	

Typical Chemical Values of Weld Metal

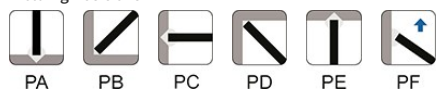
Type of Analysis	C	Si	Mn	Cr	Ni	Mo	Nb
Weld Deposit	0.02	0.80	0.90	19.00	12.00	2.90	0.25

Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	500	600	35	20°C → 70

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
3.25x300	80-120
2.50x300	50-80
5.00x350	160-230
3.25x350	80-120
2.00x250	35-55
2.50x250	50-80
4.00x350	110-160
2.00x300	35-55

Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (~)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
13021DJEM2	2.00x300	148 kg	1.8	10	18.5	VAC Box

13021GJEM2	2.50x300	95 kg	1.8	10	19.0	VAC Box
13021MJEM2	3.25x300	58 kg	1.8	10	18.5	VAC Box
13021QJEM2	4.00x350	37 kg	2.0	10	20.8	VAC Box
13021TJEM2	5.00x350	24 kg	2.0	10	18.6	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
It has to be dried at 350°C for 2 hours.