

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-318 is a titanium oxide low hydrogen electrode, the weld metal contains 8%Cr-12%Ni-2%Mo-Ti(Nb).
- Contains Mo, features non-oxidative acid of dilute sulfuric acid advantageous to anti-corrosion, besides, within an addition of Nb is advantage of intergranular corrosion and heat resistance.
- It is suitable for Chemical Container as AISI 316Ti, and SUS 316Ti steels.

NOTE ON USAGE :

- Rebake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100~150°C prior to use.
- With lower current is to properly keep the dilution of the parent metal for welding crack.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo	Nb
0.025	0.80	0.75	0.030	0.006	11.70	19.70	2.53	0.38

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
589(60.1)	39

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	50-85	80-120	100-150	140-180
	V & OH	45-80	70-110	90-135	-