

## Coated Electrode for Stainless Steels

### Classification

EN 1600 : E 19 12 3 Nb R 12  
 AWS A5.4 : (E318L-16)  
 Werkstoff-Nr : 1.4576

### General Description

AS P-318 Super is a low carbon rutile coated electrode. It gives a filler metal of the Cr-Ni-Mo type. AS P-318 Super can also be used in the welding of niobium or titanium stabilized AISI 318 or similar quality stainless steels. Excellent quality smooth weld beads are highly resistant to acids and to intergranular corrosion at operating temperatures up to 350°C. It gives a stable arc and the slag is easy to remove.

### Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	Cr	Ni	Mo	Nb
0.04	0.90	0.80	18	12	2.5	0.50

### Mechanical Properties, Typical, All Weld Metal

Yield Strength : 500 N/mm<sup>2</sup>  
 Tensile Strength : 620 N/mm<sup>2</sup>  
 Elongation (L=5d) : 35 %  
 Impact (ISO-V) : 65 J (+20°C)

### Approvals

GOST, SEPRO, TSE

### Applications and Materials to be Welded

AS P-318 Süper can be used in the welding of corrosion resistant pipes, tanks and vessels that are made of Cr-Ni-Mo type stainless steel. It is also an ideal electrode for the welding of parts that are used in chemical, food and paint industries for acid, salt, gas, vapor and water transmission.

	EN 10088-1/-2	EN 10213-4	W. Nr.
<b>Extra Low Carbon Stainless Steels</b> (C < %0.03)	X2 CrNiMo 17 12 2	–	1.4404
	X2 CrNiMo 18 14 3	–	1.4435
	X2 CrNiMoN 17 11 2	–	1.4406
	X2 CrNiMoN 17 13 3	–	1.4429
<b>Medium Carbon Stainless Steels</b> (C > %0.03)	X4 CrNiMo 17 12 2	–	1.4401
	X4 CrNiMo 17 13 3	–	1.4436
	–	G-X5 CrNiMo 19 11	1.4408
<b>Stabilized Stainless Steels</b> (Nb/Ti)	X6 CrNiMoTi 17 12 2	–	1.4571
	X6 CrNiMoNb 17 12 2	–	1.4580
	X6 CrNiNb 18 10	–	1.4550
	–	G-X5 CrNiNb 19 10	1.4552

### Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 70 V ; DC (+)

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
2.50	250	50 - 80	1570	1.4 / 90	1.5
3.25	300	70 - 120	3140	2.4 / 75	2.0
4.00	350	100 - 150	5870	4.1 / 70	2.5



1G/PA 2F/PB 2G/PC  
4G/PE 3G/PF