

Shielded Metal Arc Welding

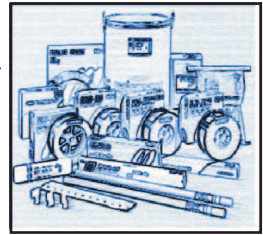
ANU BOND - 2B (E 318 -16)

AWS: SFA 5.4, E318 - 16, IS:E 19-12-2 Nb - R26

Stainless Steel Welding Electrodes

Application :

For the fabrication of chemical plants. Paper mill equipments Pickling plant etc. Joining and surfacing of similar composition of stainless steel.



Characteristics on Usage :

It is a stainless steel electrode it produces a columbium stabilized 19/12/Mo weld metal. It is all position electrode having good resistant to corrosion and improved creep strength. It is ideally suited for joining for stainless steel of similar composition the weld metal ha excellent creep strngth upto 850 oC and is of radiographic quality , recommended for welding AISI 316, 317, & 318 type stainless steel.

Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Mo	Cb
0.080 Max	0.50-2.50	1.0 Max	0.030Max	0.040 Max	17.0-20.0	11.0-14.0	2.0-2.50	0.50-1.0

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Elongation (L=4d) %
550 Min	25 % Min

Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	AC/ DC (+)	60-80
3.15 x 350	2	12		80-100
4.00 x 350	2	12		100-140
5.00 x 350	2	12		140-180

