

Standards:

EN ISO 3581-A:	E 19 12 3 Nb R 12
EN 1600:	E 19 12 3 Nb R 12
AWS A 5.4:	E 318-17
Mat.-No.:	1.4576

Approvals:

TÜV

capilla® 318 LR**Product description:**

Rutile coated stick electrode for welding of austenitic stainless Cr-Ni-Mo-steels especially for Nb-and Ti - stabilised types of steel with extra low carbon content;

Service temperatures up to. 400°C

Applications:

Suitable for materials such as:
1.4571, 1.4573, 1.4580, 1.4581,
1.4583, 1.4401, 1.4404, 1.4408,
1.4420, 1.4435, 1.4436.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mo	Nb	Fe
Min.		18	11	2,5	10 x %C	
Max.	0,03	20	13	3		Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	600	[MPa]
Yield strength $R_{p0,2}$:	440	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	30	[%]
Impact strength (ISO-V):	70	[J]

Positions: all

Redrying:: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	300	40 – 60	= (+) ~
2,5	300	50 – 90	
3,25	350	80 – 110	
4,0	350	100 – 150	
5,0	450	150 – 200	

also available:

find in table of content

Capilla 318 KB
Capilla 318 L
Capilla 318 MAG

Capilla 318 WIG
Capilla G 318 RM (tubular wire)