

Standards:		capilla® 318
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 318-16	
Mat.-No.:	1.4576	
Approvals:	TÜV, DB	

Product description:	Applications:
Rutile-basic 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	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	12	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 LR

Capilla 318 MAG
Capilla 318 WIG
Capilla G 318 RM (tubular wire)