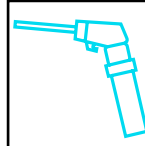


WELDING CONSUMABLES STAINLESS STEEL AND SPECIAL ELECTRODES



SECTION THREE

SATINCROME 318-17

45 OCV

AC DC+



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	490 MPa
Tensile Strength	610 MPa
Elongation	36%

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.04%	Mn: 0.8%	Si: 0.90%
Cr: 19.0%	Ni: 12.0%	Mo: 2.3%
Nb: 0.35%	S: 0.017%	P: 0.024%

FERRITE NUMBER:

5.0 - 10.0 FN*
* - using Severn Gauge

- ▲ Rutile Type, Stainless Steel Electrode.
- ▲ Outstanding Operator Appeal. Improved slag lift.
- ▲ All Positional (except vertical down) Welding Capabilities.
- ▲ Applications include the all positional (except vertical-down) fillet and butt welding of stabilised and unstabilised 19Cr/10Ni type stainless steels, such as 316, 318 and 321.

Classifications:

AS/NZS 1553.3: E318-17.
AWS/ASME-SFA A5.4: E318-17.

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Easyweld Handipaks	Part No
				2.5kg	15kg – 6 x 2.5kg	20 rod	
2.5	300	46	40 – 70	2.5kg	15kg – 6 x 2.5kg		611652
						20 rod	322105
3.2	350	28	75 – 110	2.5kg	15kg – 6 x 2.5kg		611653

WELDALL

45 OCV

AC DC+



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	630 MPa
Tensile Strength	780 MPa
Elongation	25%
CVN Impact Values	30 J av @ +20°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.11%	Mn: 0.60%	Si: 0.88%
Cr: 27.0%	Ni: 9.10%	S: 0.011%
P: 0.020%		

COMPARABLE CIGWELD PRODUCTS:

Murex Speedex 312-16
AWS A5.4: E312-16

- ▲ Easy-to-Use Rutile Type, High Alloy Electrode.
- ▲ Outstanding Operator Appeal!
- ▲ WELDS ALL Steels!
- ▲ Ideal for Repair & Maintenance jobs.
- ▲ Easy Arc Starting and Excellent Stability on Low O.C.V. Welding Machines.
- ▲ Not Recommended for Welding Cast Irons.

Classifications:

AS/NZS 1553.3 E312-17.
AWS/ASME-SFA A5.4: E312-17.

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Easyweld Handipaks	Part No
				2.5kg	15kg – 6 x 2.5kg	12kg – 12 x 1kg	
2.5	300	57	40 – 80	2.5kg	15kg – 6 x 2.5kg		611702
2.5	300	57	40 – 80	1kg	12kg – 12 x 1kg		610702
2.5	300	57	40 – 80	–	–	20 rod	322101
3.2	350	30	75 – 110	2.5kg	15kg – 6 x 2.5kg		611703
3.2	350	30	75 – 110	1kg	12kg – 12 x 1kg		610703
3.2	350	30	75 – 110	–	–	15 rod	322102
4.0	350	20	110 – 150	2.5kg	15kg – 6 x 2.5kg		611704

Easyweld Blister Pack:

10 x 2.5mm/5 x 3.2mm rod Weldall Blister Pack 322216

MUREX™ SPEEDEX 312-16

45 OCV

AC DC+



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	635 MPa
Tensile Strength	785 MPa
Elongation	25%
CVN Impact Values	30J av @ +20°C

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.10%	Cr: 26.5%	Mn: 0.62%
Ni: 9.15%	Si: 0.89%	

COMPARABLE CIGWELD PRODUCTS:

Weldall
AWS A5.4: E312-17.

- ▲ A E312-16 type stainless steel electrode designed for fillet & butt welding in all positions except vertical down.
- ▲ Speedex™ 312-16 produces low spatter levels as well as smooth running.
- ▲ Applications include the joining of stainless steel to mild steel and the welding of steels of unknown composition.
- ▲ Also suitable for repair and maintenance applications on tool and die steels.

Classifications:

AS/NZS 1553.3: E312-16.
AWS A5.4: E312-16.

Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
				2.5kg	15kg – 3 x 2.5kg	
2.5	300	55	40 – 70	2.5kg	15kg – 3 x 2.5kg	SPS31225
3.2	350	30	70 – 110	2.5kg	15kg – 3 x 2.5kg	SPS31232
4.0	350	19	110 – 150	2.5kg	15kg – 3 x 2.5kg	SPS31240