GeKa

ELOX R 318

Standards :

TS EN ISO 3581 - A	:	E 19 12 3 Nb R 32
EN ISO 3581 - A	:	E 19 12 3 Nb R 32
AWS A5.4	:	~E 318 - 16

Chemical Composition of Weld Metal- % (Typical) :

C	Si	Mn	Mo	Ni	Cr	Nb
0.04	0.8	0.8	2.8	11.0	19.4	+

Mechanical Properties :

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20 °C)	Elongation ($L_o=5d_o$)(%)
min. 390	580-750	min.47 J	min. 30

Typical Base Material Grades :

* X6CrNiMoTi 17 12 2, X6CrNiMoNb 17 12 2, X5CrNiMo 17 13 2, G-X5CrNiMo 18 10, X10CrNiMoNb 18 12, X5CrNiMo 17 13 3, G-X10CrNiMo 18 10, G-X10CrNiNb 18 10, 316 Ti, 316 Cb, 316 L

Features and Applications :

* Used for the welding of tanks and pipes made of Cr-Ni-Mo-alloyed, stabilized steels which are used in food, chemical textile and paint industries.
* The weld metal stabilized by Nb is resistant to temperatures up to +400°C.
* Re-drying : 300 - 350°C / min. 2 h

Welding Positions :

Current Type :

D.C.(+)
A.C.

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.00 x 250	5/64 x 10"	40-60	970
2.50 x 250	3/32 x 10"	50-90	1540
3.20 x 300	1/8 x 12"	80-120	2990
3.20 x 350	1/8 x 14"	80-120	3540
4.00 x 350	5/32 x 14"	110-160	5250

Approvals :

TSE, CE, GOST-R, SEPRO