

AK E318-16

Description: AK-E318-16 is a rutile-type coating containing niobium-stabilized Cr19Ni12Mo2Nb stainless steel electrode. AC and DC dual-use, can perform all-position welding. The welding process performance is excellent, and the deposited metal has better resistance to intergranular corrosion than A202 and A207.

Application: It is suitable for welding urea synthesis towers, vinylon equipment and other parts that are in contact with strong corrosive media, such as 06Cr17Ni12Mo2Ti, 06Cr17Ni12MoNb and other stainless steel structures.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.08	1.00	0.5-2.5	0.03	0.03	11.0-14.0	2.0-3.0	17.0-20.0	0.75
Actual Result	0.04	0.67	1.10	0.010	0.025	12.1	2.44	18.85	0.10

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 550		≥20	
Actual Result	610		31	

Recommended welding parameters:

Diameter/mm		2.5	3.2	4.0
Welding current/A	F/H	60-80	80-120	100-150
	V/ OH	40-70	60-100	80-130