BASINOX 318

TOP FEATURES

- Basic coated MMA electrode for welding stabilized austenitic stainless Cr-Ni-Mo steels and cast steels
- For operating temperatures of up to +400 °C
- The weld metal has high ductility
- Well-suited for positional welding.
- Easy slag release.
- Recommended for welding thicker section components.

CLASSIFICATION

AWS A5.4	E318-15
EN ISO 3581-A	E 19 12 3 Nb B 42

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Ferrite
≤0.04	1	0.4	≤0.025	≤0.020	19	11.5	2.7	0.4	5-10

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.4	AW	not specified	min. 550	min. 25	not specified
EN ISO 3581-A	AW	min. 350	min. 550	min. 25	not specified
Typical values	AW	380	600	30	50

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x300	45-80
3.2x350	50-125
4.0x350	90-150

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	105	1.8	W000288007
3.2 x 350	VPMD	65	2.2	W000288008
4.0 x 350	VPMD	45	2.2	W000288009

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.