

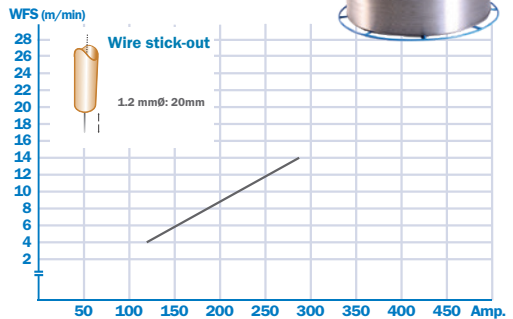
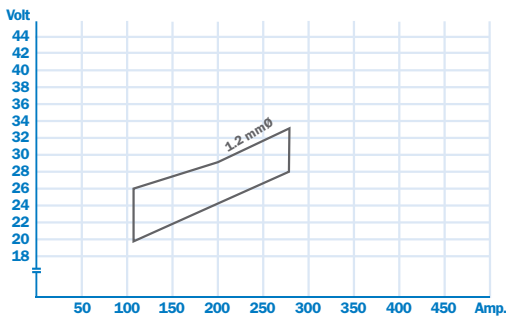
## Description and Application

This is a rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

**DW-318** is designed for welding 18%Cr-12%Ni-2%Mo-Nb or Ti stainless steel. Due to its Mo and Nb content, DW-318 provides good resistance against intergranular corrosion and non-oxidizing acid.



### Recommended Parameter Range, for flat position\*



### Typical Chemical Analysis (wt. %)

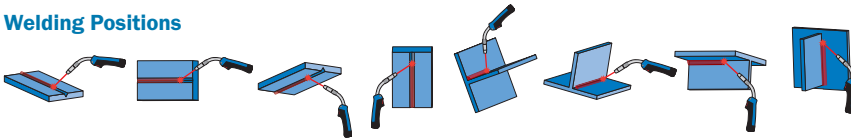
| C    | Si   | Mn   | P    | S     | Ni   | Cr   | Mo  | N | Nb  | FS  | FN   | FNW  |
|------|------|------|------|-------|------|------|-----|---|-----|-----|------|------|
| 0.02 | 0.50 | 1.30 | 0.02 | 0.012 | 11.6 | 18.5 | 2.8 | - | 0.4 | 8.9 | 16.0 | 12.9 |

### Typical Mechanical Properties

|          | R <sub>e</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | CV(J)0°C |
|----------|----------------------|----------------------|--------------------|----------|
| Guaranty | 511                  | 680                  | 31                 | 57       |
|          | min.350              | min.550              | min.25             |          |

\* The above values and parameters are for all weld metal produced using Ar+CO<sub>2</sub> shielding gas

### Welding Positions



### Approvals

| LR | DNV GL | BV | ABS | R.M.R.S | Others |
|----|--------|----|-----|---------|--------|
| -  | -      | -  | -   | -       | -      |