

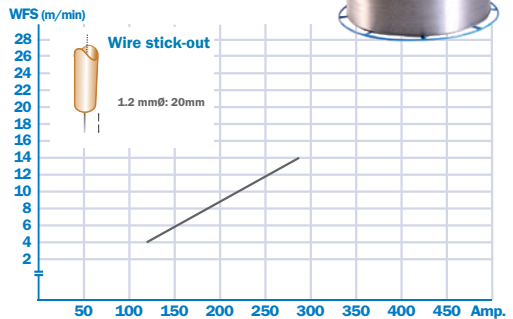
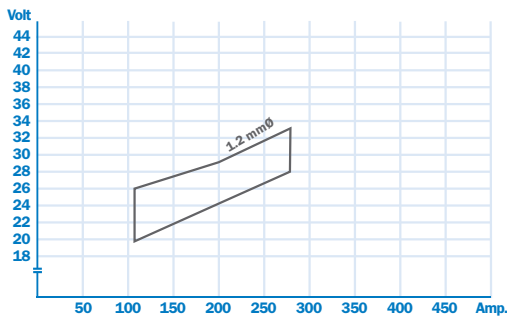
## Description and Application

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. %)

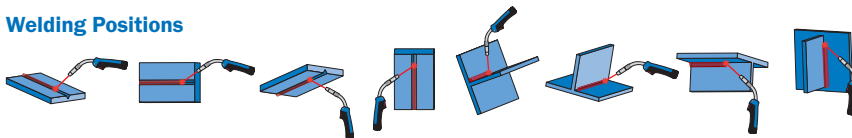
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.02	0.50	1.30	0.02	0.012	11.6	18.5	2.8	-	0.4	8.9	16.0	12.9

### Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)0°C
	511	680	31	57
Guaranty	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	BV	ABS	R.M.R.S	Others
-	-	-	-	-	CE