

CLASSIFICATIONS

EN ISO 14343-A : G 19 12 3 Nb Si

AWS A5.9 : ~ER 318

DESCRIPTION

- Used for the welding of 13% ferritic stainless steels or stainless steels which have the similar chemical analysis to welding wires that are used in the chemical, textile, paint and food industries
- Weld metal is resistant to corrosion up to +400°C and chlorine
- Suitable for MIG welding
- Ar+ %2.5 O₂ or Ar+ %2.5 CO₂ mixed gases are the shielding gases.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.035 | Si: 0.8 | Mn: 1.4 | Cr: 19.9 | Ni: 11.5 | Mo: 2.8 | Nb: +

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/+20°C)	Elongation (L _o =5d _o) (%)
min. 390	600 - 780	min. 63 J	min. 30

BASE MATERIALS

- X6 CrNiMoTi 1712 2, X6 CrNiMoNb 1712 2, X5 CrNiMo 1712 2, G-X5 CrNiMoNb 1810, G-X10 CrNiMo 18 10, X10 CrNiNb 1810, X10 CrNiMoNb 1812
- AISI: 316, 316Cb, 316L, 316Ti

WELDING POSITIONS



CURRENT CONDITION

MIG D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100059	1.0	0.040"	15	BS 300
1011100060	1.2	0.047"	15	BS 300