

CLASSIFICATIONS

EN ISO 14343-A : W 19 12 3 Nb
 AWSA5.9 : ER 318

DESCRIPTION

- TIG welding of 13% ferritic stainless steels as well as of stainless steels of similar chemical compositions as those of welding wires used in chemical, textile, paint, food and synthetic resin production
- As the shielding gas, argon(Ar) is used
- Maintenance of resistance to intergranular corrosion at temperature values up to 400 °C

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.035 | Si: 0.50 | Mn: 1.7 | Cr: 19.6 | Ni: 11.4 | Mo: 2.7 | Nb: +

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 440	640 - 780	min. 63 J	min. 30

BASE MATERIALS

- X6 CrNiMoTi 1712 2, X6 CrNiMoNb 1712 2, X5 CrNiMo 1712 2, G-X5 CrNiMoNb 18 10, X10 CrNiMoNb 18 12
- AISI: 316, 316Cb, 316L, 316Ti

WELDING POSITIONS



CURRENT CONDITION

TIG D.C.(-)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100056	1.6 x 1000	1/16 x 39"	5	Plastic Box
1011100057	2.0 x 1000	5/64 x 39"	5	Plastic Box
1011100058	2.4 x 1000	3/32 x 39"	5	Plastic Box