

Standards: AWS/ASME SFA-5.9

ER 318

Application/ Properties: Stabilized austenitic stainless welding rod for TIG welding of stabilized corrosion resistant Cr Ni Mo steels. Resistant to intergranular corrosion up to 400 C.

Analysis of Wire electrode% (Typical value) :

| C | Cr | Si | Ni | Mo | Nb |
|-------|-------|----------|-------|-----|------|
| <0.08 | 18-20 | 0.3-0.65 | 11-14 | 2-3 | >8xC |

Shielding gas: 100% Ar

Mechanical properties of all -weld metal :

| Tensile Strength (N/mm ²) | 0.2% Proof Stress (N/mm ²) | Elongation Lo = 4d % | Impact energy (j) (J) ISO - V 25 °C |
|--|---|----------------------------|---|
| >550 | >350 | >25 | >65 |

Material:

DIN EN standard 1.4401 X5CrNiMo 17 12 2 ; 1.4406 X2CrNiMoN 17 12 2 ; 1.4408 G-X6CrNiMo 18 10 ; 1.4436 X5CrNiMo 17 13 3 ; 1.4581 G-X5CrNiMoNb 18 10 ; 1.4571 X6CrNiMoTi 17 12 2 ; 1.4580 X6CrNiMoNb17 12 2 ; 1.4583 X10CrNiMoNb 18 12

other Standard AISI 316L, 316Ti, 316Cb

Delivery: welding rods

weight :5 kg.

diameter : 1-4 mm.

Length: 1000mm.

Note: other weight & sizes are produced upon customers request.

