



# CEWELD 318Si

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                          |                      |        |                         |       |          |
|---------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------|----------------------|--------|-------------------------|-------|----------|
| TYPE                                              | Solid stabilized stainless steel welding wire with high Mo content                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                          |                      |        |                         |       |          |
| TOEPASSINGEN                                      | Constructions in chemical industries like apparatus and vessels up to working temperatures of approximately 120 °C up to 400 °C.                                                                                                                                                                                                                                                                                                                                                                                                       |                          |                      |        |                         |       |          |
| EIGENSCHAPPEN                                     | Applicable for welding of joints and surfacings of stabilized, corrosion resistant CrNiMo steels.Excellent corrosion resistance as needed in chemical industry up to 400°C and good weldability with excellent flowing properties due to the increased Silicon content                                                                                                                                                                                                                                                                 |                          |                      |        |                         |       |          |
| CLASSIFICATIE                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A 5.9: ~ER318            |                      |        |                         |       |          |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 14343-A: G 19 12 3 Nb Si |                      |        |                         |       |          |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 1.4576                   |                      |        |                         |       |          |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 6                        |                      |        |                         |       |          |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 5                        |                      |        |                         |       |          |
| GESCHIKT VOOR                                     | <b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr</b><br>1.4301, 1.4306, 1.4401, 1.4404, 1.4408, 1.4420, 1.4435, 1.4436, 1.4541, 1.4550, 1.4571, 1.4573, 1.4579, 1.4580, 1.4581, 1.4583<br>X 6 CrNiMoTi 17 12 2, X10 CrNiMoTi 18 12, X 6 CrNiMoNb 17 12 2, G-X 5 CrNiMoNb 18 10, X 10 CrNiMoNb 18 12, X 5 CrNiMo 18 11, X 2 CrNiMo 17 13 2, G-X 2 CrNiMo 18 10, X 2 CrNiMo 18 14 3, X 5 CrNiMo 17 12 2, G-X 6 CrNiMo 18 10, X 5 CrNiMo 17 13 3, X6CrNiMoTi17-12-2S<br>UNS S31600, S31603, S31635, S31640, S31653,<br>AISI 316, 316L, 316Ti, 316Cb |                          |                      |        |                         |       |          |
| GOEDKEURINGEN                                     | TÜV: (12390), CE, DB: (43.206.03)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                          |                      |        |                         |       |          |
| LASPOSITIES                                       | <div>     </div>     |                          |                      |        |                         |       |          |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Si                       | Mn                   | Cr     | Ni                      | Mo    | Nb       |
|                                                   | 0.07                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.5                      | 2                    | 19     | 12.5                    | 2.8   | 0.5      |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | R <sub>P0,2</sub> (MPa)  | R <sub>m</sub> (MPa) | A5 (%) | Impact Energy (J) ISO-V |       | Hardness |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 460                      | 615                  | 35     | RT                      | -60°C | HRc      |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                          |                      |        |                         |       |          |
| GAS ACC. EN ISO 14175                             | M13, M12                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                          |                      |        |                         |       |          |



# CEWELD 318Si

## 318Si 0,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415103 |
| D-200     | 5       | 8720663415110 |

## 318Si 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415127 |
| D-200     | 5       | 8720663415141 |
| Drum      | 250     | 8720663415134 |

## 318Si 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415158 |

## 318Si 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415165 |