

MIGWELD 318Si

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 19 12 3 Nb Si DIN 8556 : S-GX5 CrNiMoNb19 12 3 AWS A-5.9 : ER 318Si W.Nr. : 1.4576		Power generation industry Constructions & Engineering Metallurgy (Steelworks) Petrochemical and chemical industry

- Solid welding wire for welding single-grade stainless steels, both stabilized and non-stabilized with Nb, resistant to corrosion from chemical agents.
- Suitable for use in all industries where homogeneous CrNiMo steel grades are welded, up to a temperature of 400°C.
- Oxidation resistant weld metal up to 800°C.

Application

Used for tanks for acids, salts, and alkalis, valves and pipes in the chemical, textile, dye and paper industries.

Base material

PN	DIN	W.Nr.	AISI/ASTM
0H17N12M2T	X5CrNiMo 17 12 2	1.4401	316
	X5CrNiMo 17 13 3	1.4436	316
H17N13M2T, H18N10MT	X6CrNiMoTi 17 12 2	1.4571	316Ti
	X6CrNiMoNb 17 12 2	1.4581	316Cb
	X10CrNiMoTi 18 12	1.4573	316Ti
	X10CrNiMoNb 18 12	1.4583	316Cb
	G-X6CrNiMo 18 10	1.4408	A157
	G-X5CrNiMoNb 18 10	1.4581	316L
	G-X 10CrNiMo18 9	1.4410	A 351 GradeCF3M
00H17M14M2	X2 CrNiMo17 13 3	1.4404	316L
	X2 CrNiMo18 12	1.4435	316L
	X6 CrNiMoNb17 12 2	1.4580	316Cb
	X2 CrNiMoN17 11 2	1.4406	316LN
	X2 CrNiMoN17 13 3	1.4429	
0H18N12Nb	X6 CrNiNb18 10	1.4550	347
	G-X5 CrNiNb19 10	1.4552	Cf-8C
	X5 CrNiMo17 13	1.4449	318
	G-X6 CrNiMo18 12	1.4437	CF-8M

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	Nb
<0,05	0,80	1,50	19,00	12,00	2,80	12x%C

Typical mechanical properties

Yield strength Re [N/mm ²]	>380
Tensile strength Rm [N/mm ²]	>550
Elongation A5 [%]	>30

Impact energy Kv [J]	>70J (20°C) /
Wire/rod type	Solid
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	I1 - Ar / M12 - Ar + 0.5 - 5% CO2 / M13 - Ar + 0.5 - 3% O2 /

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	100-160	18-22	15,0
1,0	140-200	18-24	15,0
1,2	170-260	20-28	15,0
1,6	220-350	24-36	15,0

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