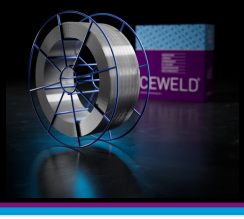


CEWELD 318Si

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid stabilized stainless steel welding wire with high Mo content

APPLICATIONS

CEWELD® 318Si is ideal for joining and overlay welding of identical or similar austenitic CrNi(N) and CrNiMo(N) steel grades as well as cast steel alloys. It is ideal for welding titanium- or niobium-stabilized austenitic stainless steels containing molybdenum.
It is suitable for structures in the chemical industry, such as apparatus and containers, which are exposed to operating temperatures of approximately -120 °C to 400 °C.

PROPERTIES

CEWELD® 318Si exhibits excellent corrosion resistance, as required in the chemical industry at temperatures up to 400°C, with good weldability and excellent flow properties due to its increased silicon content.

CLASSIFICATION

AWS	A 5.9: ~ER318
EN ISO	14343-A: G 19 12 3 Nb Si
F-nr	6
FM	5
W.Nr.	1.4576

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr
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
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
UNS S31600, S31603, S31635, S31640, S31653,
AISI 316, 316L, 316Ti, 316Cb

APPROVALS

TÜV ((12390)) CE DB ((43.206.03))

WELDING POSITIONS

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

ALL WELD MECHANICAL PROPERTIES

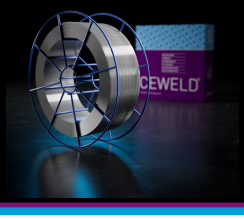
Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	Impact Energy (J) ISO-V -60°C
As Welded /	460	615	35	100	70

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

M13, M12



CEWELD 318Si

certilas® THE FILLER METAL SPECIALIST

318SI 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663415103
D-200	5	8720663415110

318SI 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663415127
D-200	5	8720663415141
Drum	250	8720663415134

318SI 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663415158

318SI 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663415165