
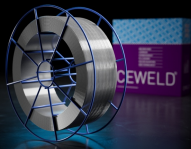


CEWELD 318Si

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	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ~ER318</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 19 12 3 Nb Si</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4576</td> </tr> </table>	AWS	A 5.9: ~ER318	EN ISO	14343-A: G 19 12 3 Nb Si	F-nr	6	FM	5	W.Nr.	1.4576							
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EN ISO	14343-A: G 19 12 3 Nb Si																	
F-nr	6																	
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W.Nr.	1.4576																	
SUITABLE FOR	<p>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</p>																	
APPROVALS	TÜV ((12390)) CE DB ((43.206.03))																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Nb</th> </tr> </thead> <tbody> <tr> <td>0.07</td> <td>0.5</td> <td>2</td> <td>19</td> <td>12.5</td> <td>2.8</td> <td>0.5</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	Nb	0.07	0.5	2	19	12.5	2.8	0.5			
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th>R_{P0,2}</th> <th>R_m</th> <th>A₅</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>MPa</th> <th>MPa</th> <th>(%)</th> <th>RT</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>460</td> <td>615</td> <td>35</td> <td>100</td> <td>70</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2}	R _m	A ₅	Impact Energy (J) ISO-V		MPa	MPa	(%)	RT	-60°C	As Welded /	460	615	35	100	70
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	MPa	MPa	(%)	RT	-60°C													
As Welded /	460	615	35	100	70													
REDRYING TEMPERATURE	Not required																	
GAS ACCORDING EN 14175	M13, M12																	



CEWELD 318Si

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