



CEWELD 318Si

TYPE Solid stabilized stainless steel welding wire with high Mo content

APPLICATIONS Constructions in chemical industries like apparatus and vessels up to working temperatures of approximately 120 °C up to 400 °C.

PROPERTIES 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

CLASSIFICATION

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

SUITABLE FOR 1.4301, 1.4306, 1.4401, 1.4404, 1.4408, 1.4420, 1.4435, 1.4436, 1.4541, 1.4550, 1.4571, 1.4573, 1.4580, 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
 UNS S31600, S31603, S31635, S31640, S31653,
 AISI 316, 316L, 316Ti, 316Cb

APPROVALS TÜV: 12390.00, CE, DB: 43.206.03

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo
0.07	0.5	2	19	12.5	2.8

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-60°C	
As Welded	460	615	35	100	70	HRc

REDRYING 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