



# CEWELD AA 318

**TYPE** Stabilized stainless steel rutile cored wire with high Mo content

**APPLICATIONS** Developed for welding of stabilized CrNi(N) and CrNiMo(N) types.

**PROPRIÉTÉS** Flux cored wire with slag support for high productivity welding in all positions. Excellent for use on ceramic backing strips. The slag is self detaching and offers extra protection to obtain X-ray proof weld seams with practically no spatters. Better wetting and welding properties with more productivity compared to solid wires

**CLASSIFICATION**

|        |                               |
|--------|-------------------------------|
| EN ISO | 17633-A: T 19 12 3 Nb P M21 1 |
| W.Nr.  | 1.4576                        |
| FM     | 5                             |

**CONVIENT POUR** 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

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**



**ANALYSE CHIMIQUE  
 TYPIQUE DU MÉTAL DE  
 SOUDURE (%)**

| C     | Si   | Mn   | Cr    | Ni   | Mo   | Cu   | N     | Nb   |
|-------|------|------|-------|------|------|------|-------|------|
| 0.029 | 0.58 | 1.34 | 18.64 | 11.5 | 2.78 | 0.05 | 0.032 | 0.36 |

**PROPRIÉTÉS MÉCANIQUES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|----------|
|                |                         |                      |                    | 0°C                     |          |
| As Welded      | 500                     | 670                  | 31                 | 60                      | HRC      |

**ETUVAGE** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21



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AA 318 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413635 |