



# CEWELD SA 318

**TYPE** Solid stainless steel welding wire for submerged arc welding stabilized stainless steels with high Mo content

**TOEPASSINGEN** The alloy is widely used in the chemical and food-processing industries, as well as in shipbuilding. Suitable for welding stabilized corrosion-resistant Cr-Ni-Mo steels for working temperatures up to 400°C.

**EIGENSCHAPPEN** CEWELD® SA 318 is engineered to a very precise analysis to create a weld deposit of high purity, superior hot cracking and corrosion resistance. CVN toughness down to -120 °C, resistant to intergranular corrosion up to 400 °C. Flux CEWELD® FL 838 or fused flux CEWELD® FL 880

**CLASSIFICATIE**

|        |                       |
|--------|-----------------------|
| EN ISO | 14343-A: S 19 12 3 Nb |
| W.Nr.  | 1.4576                |
| F-nr   | 6                     |
| FM     | 5                     |

**GESCHIKT VOOR** 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

**GOEDKEURINGEN** CE

**LASPOSITIES**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

| C     | Si  | Mn  | P    | S    | Cr | Ni   | Mo   | Nb  |
|-------|-----|-----|------|------|----|------|------|-----|
| 0.035 | 0.5 | 1.6 | 0.02 | 0.02 | 19 | 12.5 | 2.75 | 0.6 |

**MECHANISCHE WAARDEN**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
|                |                         |                      |                    | RT                      | -110°C |          |
| As Welded      | 390                     | 590                  | 30                 | 110                     | 47     | HRc      |

**HERDROGEN** Not required

**GAS ACC. EN ISO 14175**