CEWELD AA 318

certilas® THE FILLER METAL SPECIALIST

TYPE

Stabilized stainless steel rutile cored wire with high Mo content

APPLICATIONS

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

PROPERTIES

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

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

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V 0°C	Hardness
As Welded	500	670	31	60	HRc

REDRYING

140°C / 24 hr

GAS ACC. EN ISO 14175

M21

CEWELD AA 318

AA 318 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413635