

## AA 318

CATEGORY FCAW Flux-Cored

TYPE Rutile fluxcored stabilized stainless steel wire with high Mo content

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

CLASSIFICATION

AWS	A 5.22: E 318 T 0-4 A 5.22: E 318 T 0-1
EN ISO	17633-A: T 19 12 3 Nb R M 3
DIN: W.Nr.	1.4576
DIN	8556: 19 12 3 Nb

SUITABLE FOR 1.4583 X102CrNiMoNb 18 12 316Cb 1.4404, X2CrNiMo 17 12 2, (TP) 316L 1.4401, X4CrNiMo 17 12 2, (TP) 316 1.4571 X6CrNiMo 17 12 2 316 Ti, 1.4580, X6CrNiMoNb 17 12 3, 316Cb 1.4581 G-X5CrNiMoNb 19 11 2, 1.4437 G-X6CrNiMo 18 12, 1.4406, X2CrNiMoN 17 12 3, (TP)316LN

APPROVALS CE approved

WELDING POSITIONS:



TYPICAL WELD DEPOSIT ANALYSIS (WEIGHT %)

C	Mn	Si	Cr	Ni	Mo	Nb	P	S	FN	FNW
0.02	1.3	0.5	18.5	11.6	2.8	0.4	0.02	0.012	16	12.9

MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	0°C	Impact Energy (J) ISO-V		Hardness HRC / HV
					-40°C	-60°C	
AW	500	670	31	57			

AW - as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2	20-33	125-280	D-200 / BS-300	5 / 15	1080

REDRYING TEMPERATURE 150°C/24hr

GAS ACC. EN ISO 14175: M21