

CATEGORY	SAW Arc Submerged	
TYPE	Solid stainless steel welding wire for submerged arc welding stabilized stainless steels with high Mo content	
APPLICATIONS	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.	
PROPERTIES	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	
CLASSIFICATION	AWS EN ISO F-nr FM W.Nr.	A 5.9: ER318 14343-A: S 19 12 3 Nb 6 5 1.4576
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
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TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.035	0.5	1.6	0.02	0.02	19	12.5	2.75

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	RT	Impact Energy (J) ISO-V
As Welded /	390	590	30	110	-110°C 47

WELDING PARAMETERS / PACKING

D (MM)	WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
	VOLTAGE (V) (DC+)	CURRENT (A)		SPOOL TYPE	KG / SPOOL	KG / PALLET
1,6	27-30	200-300		K-415	25	1050
2,4	29-33	300-400		K-415	25	1050
3,2	29-33	350-500		K-415	25	1050
4,0	30-36	400-600		K-415	25	1050

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	
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