

# CEWELD SA 318

**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.

**PROPRIÉTÉS** 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	A 5.9: ER318
EN ISO	14343-A: S 19 12 3 Nb
W.Nr.	1.4576
F-nr	6
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**



**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

**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
				RT	-110°C	
As Welded	390	590	30	110	47	HRC

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175**