

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 318Si is a stainless steel solid wire suitable for welding stabilized austenitic steels such as AISI 318. Nb + Ta additions improve the oxidation resistance of the weld deposit.

Classification	
AWS	A5.9: ER318 (similar)
EN	12072: G 19 12 3 Nb Si

Approvals	Grades
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.07	1.75	0.85	≤ 0.020	≤ 0.020	19	12.60	2.60	0.70	-	-	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 400	≥ 550	≥ 30	≥ 47	-

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

1.4571 (X6CrNiMoTi17-12-2) - 1.4401 (X4CrNiMo17-12-2)

1.4580 (X6CrNiMoNb17-12-2) - 1.4408 (GX5CrNiMo19-11)

1.4581 (GX5CrNiMoNb19-10) - 1.4436 (X4CrNiMo17-13-3)

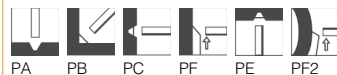
1.4583 (X10CrNiMoNb18-12)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: BS300 Kg. 15

Diameters	1,0	1,2				
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