

## Cored Wires Stainless and Heat resistant steels

Fluxinox 318 is an alloyed rutile flux cored wire for the welding of unstabilized and stabilized corrosion resistant Cr Ni Mo-steels. The weld metal is resistant to intergranular corrosion up to 400 °C and non-scaling up to 800 °C. Fluxinox 318 is characterized by excellent, almost spatter-free, welding properties with very easy slag removal from fillet welds, even in acute angles. The weld beads produced are finely rippled and free of undercut and the weld surface is shiny.

Classification	
EN	12073: T 19 12 3 Nb R M 3
EN	12073: T 19 12 3 Nb R C 3

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.04	1.50	0.80	-	-	19	12	2.80	0.40	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) - 60 °C	Hardness
As Welded	≥ 350	≥ 550	≥ 25	≥ 32	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

### 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:** K300 kg, 16

Diameters	1,2					