

Cored Wires Stainless and Heat resistant steels

Fluxinox 318-PF is an alloyed rutile cored wire with a fast-freezing slag for the welding of unstabilized and stabilized corrosion resistant CrNiMo steels. The weld metal is resistant to intergranular corrosion up to 400°C, and non-scaling up to 800°C. Fluxinox 318-PF exhibits outstanding, 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 with a shiny weld surface. Due to its fast-freezing slag, Fluxinox 318-PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
EN	12073: T 19 12 3 Nb P M 1
EN	12073: T 19 12 3 Nb P C 1

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 ²	Tensile Strength N/mm ²	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+



PA PB PC PF PE

Packaging data: K300 kg, 16

Diameters	1,2					
-----------	-----	--	--	--	--	--