

GETIG 318



IDENTIFICATION : ER 318

CLASSIFICATION :AWS/SFA 5.9 ER 318 BS 2901- 90 318 S 97 DIN 8556 SGX5CrNiMoNb 19 12

DESCRIPTION :

Getig 318 is designed for welding the Nb or Ti stabilised 18 Cr/12%Ni /2.5%Mo austenitic stainless steel grade 316Cb and 316 Ti. It is primarily intended for use at service temperatures above 400°C.

TYPICAL USES :

- ASTM/ASME type 316 Ti, 316 Cb, CF 10MC
- DIN : 1.45 71/ 1.45 73, 1.45 80/1.45 83

Shielding gas :

Argon 99.99 Pure, with back purge.

Corrosion resistance :

Good resistance to general and intergranular corrosion in dilute hot acids. Good resistance to chloride pitting corrosion as well as oxidation and corrosion at elevated temperature.

CHEMICAL COMPOSITION OF THE WIRE % :

C	Mn	Si	Cr	Mo	Ni	S	P	Cu	Nb
0.07 max	1.0 -2.50	0.30-0.65	18.0-20.0	2.0-3.0	11.0-14.0	0.025 max	0.030 max	0.50 max	8x%C min or 0.75 max

MECHANICAL PROPERTIES OF THE WELD METAL:

Ult. Tensile Strength MPa	0.2% Proof Stress MPa	Elongation (%) (L=4D)	Charpy V-notch impact strength, in joules	
560-660	430-520	30-40	Temp	Joules
			+20	55-100

PACKING DATA :

SIZE (mm)	LENGTH (mm)	PACKING PER CARTON
1.6	1000	5Kg
2.00	1000	5Kg
2.40/2.50	1000	5Kg
3.15/3.20	1000	5Kg