

# **INERTFIL 318 Si**

Drôt pre zváranie MAG/TIG

Welding rod/wire electrode for TIG/MAG-welding process

Pręty/druty do spawania metodami TIG/MAG

**Standards:**

DIN EN 12072

W / G 19 12 3 Nb

DIN 8556

SG X 5 Cr Ni Mo Nb 19 12

AWS/ASME SFA-5.9

(ER 318)

Comparable No. of Materials:

1.4576

**SK Vlastnosti a použitie:**

Austenitic zvárací drôt so stabilizátorm (Nb) pre zváranie nestabilizovaných a stabilizovaných nehrdzavejúcich CrNiMo ocelí metódou TIG a MAG. Odolný proti medzikrystalickej korózii pri prevádzkových teplotách do 400 °C.

**GB Applications and properties:**

Stabilized austenitic stainless welding rod or wire electrode for TIG/MAG-welding of unstabilized and stabilized, corrosion resisting Cr Ni Mo-steels. Resistant to intergranular corrosion up to 400 °C.

**POL Zastosowania i właściwości:**

Pręty do spawania lub rury ze stabilizowanej austenitycznej stali nierdzewnej do spawania stabilizowanych lub niestabilizowanych stali nierdzewnych Cr-Ni-Mo metodą TIG/MAG. Stopniowo odporne na korozję międzykrytaliczną do 400°C.

**Materials for instance:**

No. of Materials	EN-Designation	No. of Materials	EN-Designation
1.4401	X4CrNiMo17-12-2	1.4571	X6CrNiMoTi17-12-2

**Approvals:** TÜV, TÜV Austria, DB, ÖBB**Rod and wire analysis correspond to all-weld metal analysis (typical values in %)**

C	Si	Mn	Cr	Ni	Mo	Nb	P	S
0,07	0,85	1,75	19,00	12,60	2,60	0,70	≤0,020	≤0,020

**Mechanical properties of all-weld metal (single values are typical values):**

Heat treatment	0,2 % Proof stress [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation A <sub>5</sub> [%]	Impact energy ISO-V [J] +20 °C
AW	≥400	≥550	≥30	≥47

AW = as-welded

Analysis and mechanical properties apply to the use of shielding gas:

DIN EN 439 - I1 in TIG – welding

DIN EN 439 - M13 in MAG – welding

**Shielding gas acc. to DIN EN 439:**

Welding rod for TIG-welding:

I1 (ARCAL 1)

Wire electrode for MAG -welding:

M12 (ARCAL 12), M13 (INARC S 3)

Consumption:

TIG = approx. 10 l/min, MAG = approx. 15 l/min

**Form of delivery:**

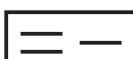
Welding rods						
Dia. [mm]	1,0	1,6	2,0	2,4	3,2	4,0
Length [mm]			1000			
Approx. Weight of packet [kgs]			10			

**Wire electrodes**

Dia [mm]	0,8	1,0	1,2	1,6
Wire cage reel K300 [kgs]		15		

**Further forms of delivery on request.****Type of current/Polarity/Welding positions:**

TIG



MAG

