

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

DIN 8556

AWS/ASME SFA-5.9

Comparable No. of Materials:

W / G 19 12 3 Nb

SG X 5 Cr Ni Mo Nb 19 12

(ER 318)

1.4576

SK Vlastnosti a použitie:

Austenitický zvärací drôt so stabilizátorom (Nb) pre zváranie nestabilizovaných a stabilizovaných nehrdzavejúcich CrNiMo ocelí metódou TIG a MAG. Odolný proti medzikryštalickej 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 własności:

Pręty do spawania lub ruty ze stabilizowanej austenitycznej stali nierdzewnej do spawania stabilizowanych lub niestabilizowanych stali nierdzewnych Cr-Ni-Mo metodą TIG/MAG. Stopiwo odporne na korozję międzykryształiczną 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 ²]	Tensile strength [N/mm ²]	Elongation A ₅ [%]	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:

