

**Standards**

TS EN ISO 14343-A	: G 19 12 3 Nb Si
EN ISO 14343-A	: G 19 12 3 Nb Si
AWS A5.9	: ~ER 318

**Chemical Composition of  
Welding Wire % (Typical)**

C	Si	Mn	Cr	Ni	Mo	Nb
0.035	0.8	1.4	19.9	11.5	2.8	+

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))
min. 390	600 - 780	min. 63 J	min. 30

**Typical Base Material Grades**

- X6 CrNiMoTi 1712 2, X6 CrNiMoNb 1712 2, X5 CrNiMo 1712 2, G-X5 CrNiMoNb 1810, G-X10 CrNiMo 18 10, X10 CrNiNb 1810, X10 CrNiMoNb 1812
- AISI: 316, 316Cb, 316L, 316Ti

**Features and Applications**

- Used for the welding of 13% ferritic stainless steels or stainless steels which have the similar chemical analysis to welding wires that are used in the chemical, textile, paint and food industries
- Weld metal is resistant to corrosion up to +400°C and chlorine
- Suitable for MIG welding
- Ar+ %2.5 O<sub>2</sub> or Ar+ %2.5 CO<sub>2</sub> mixed gases are the shielding gases.

**Welding Positions**

**Current Type**

MIG D.C.(+)

**Operating Data**

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100357	1.0	0.040"	15	BS 300
6011100406	1.2	0.047"	15	BS 300

**Approvals:** CE, SEPRO