



MIG 318Si

Standards

AWS 5.9	EN ISO 14343-A	W. Nr.
ER 318Si	G 19 12 3 NbSi	1.4576

Description & applications

Filler metal in solid wire spools for MIG welding of austenitic stainless steels. Grade 318Si is stabilized with Niobium to avoid intergranular corrosion in weldments; the high Silicon content increases the wettability of the molten metal. Niobium also improves creep resistance up to 400 °C.

Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Mo	S max	P max	Fe
0.03	1.5	0.85	19.0	12.5	2.8	0.02	0.02	Base

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV -196°C
620 MPa	450 MPa	35 %	25 J

Operating parameters

Shielding gas recommendations :

EN ISO 14175 M12 : Argon + 2-3% CO₂ or Argon + 1-2 % O₂ / 12-18 l/mn



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