



MIG 20/10MNBS

Old reference: MIG 318Si

Classification

ISO 14343-A : G 19 12 3 Nb Si
 AWS A5.9 : ER318Si

Material N° : 1.4576

Description & Applications

Low carbon solid wire for joining of stabilised stainless steels (318, 316Ti...) Good inter-granular corrosion resistance. Service temperature from -120°C up to +400°C.

Main application: Petrochemical industries and for sea water applications...

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Fe
0.02	0.85	1.6	18.5	12.0	2.7	0.1	0.5	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
400	610	35	+20°C 110

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	100-150	22-27	Ar + 2%CO ₂ Ar + 1%O ₂ 18-20 l/min
	1.0	120-200	24-28	
	1.2	140-220	24-28	
	1.6	180-260	24-30	

Ind.10



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