



TIG 20/10MNB

Old reference: TIG 318

Classification

ISO 14343-A : W 19 12 3 Nb
 AWS A5.9 : ER318

Material.N° : 1.4576

Description & Applications

Low carbon solid rod for TIG welding of stabilised stainless steels (318, 316Ti...). Good intergranular resistant corrosion. Service temperature from -120°C up to +400°C. The TIG process is particularly suited for welding of piping systems, works of fine thinness equal or inferior than 3 mm and for penetration passes.

Main applications: Applied in the petrochemical industries and for sea water applications...

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Nb	Cu	P	S	Fe
0.04	0.4	1.7	19.6	11.5	2.6	0.6	0.2	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
400	620	35	+20°C 120

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

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