

Solid Wire Electrode for MIG/MAG Welding

BA-MIG 318

Classification: EN ISO 14343-A: **G 19 12 3 Nb**
SFA-5.9: **ER318**

Main Application:

BA-MIG 318 is a solid wire electrode for GMAW, suitable to weld 19Cr/12Ni/3Mo stabilized Ti grades like 1.4571 / 316Ti. Also suitable for the welding of similar unstabilized grades 316 or 316L. BA-MIG 318 is suitable for service temperatures from -120 °C to +400 °C and has high resistance to intergranular corrosion.

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9: (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	Nb	P	S	Cu total
Typical analysis BA-MIG 318	0.04	0.45	1.7	2.6	12.0	19.0	0.6	0.020	0.013	0.15
G 19 12 3 Nb acc. to ISO 14343-A	0.08	0.65	1.0-2.5	2.5-3.0	11.0-14.0	18.0-20.0	10xC to 1.0	0.03	0.02	0.3
ER318 acc. to AWS A5.9	0.08	0.3-0.65	1.0-2.5	2.0-3.0	11.0-14.0	18.0-20.0	8xC to 1.0	0.03	0.03	0.75

All - Weld Metal Mechanical Properties / Welding Data:

Heat Treatment: As Welded
Yield Strength Re, N/mm² (ksi): 380 (55)
Tensile Strength Rm, N/mm² (ksi): 550 (80)
Elongation A5 [%]: >25
Impact Energy ISO-V, J (ft lbs): +20°C: 70 (52)
Current/polarity: DC +
Shielding Gas: ISO 14175: M13

Base Materials:

1.4571/ X6CrNiMoTi17-12-2, 1.4580/ X6CrNiMoNb17-12-2, 1.4401/ X5CrNiMo17-12-2, 1.4581/ GX5CrNiMoNb19-11-2, 1.4437/ GX6CrNiMo18-12, 1.4583/ X10CrNiMoNb18-12, 1.4436/ X3CrNiMo17-13-3, AISI 316L, 316Ti, 316Cb

Package Forms:

Spools BS300/15 kg, D200/5 kg, and drums as standard package forms for GMAW wire electrodes.

Diameter:

0,8 – 1,6 mm. Sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire Electrode Surface:

Smooth finish free from surface defects and foreign matter.