



MIG 19/13S

Classification

ISO 14343-A : G Z 19 13 Si N L

Description & Applications

Low carbon solid wire for GMAW of stainless steels with similar chemical composition like alloy X1CrNiSi 18-15-4 (UR® S1). High corrosion resistance in nitric acid environment.

Main applications: Storage of nitric acid.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	P	S	Co	Ti	B	N
Min												
Max												
Type	0.010	4.0	1.7	18.2	12.7	0.03	0.015	0.005	0.030	0.005	0.001	0.075

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	-	-	-	-
Max	-	-	-	-
Type	270	585	40	-

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	70 - 180	18 - 26	ISO 14175: M12 (Ar+0.5-5%CO ₂) M13 (Ar+0.5-3%O ₂) 15-20 l/min
	1.0	80 - 220	18 - 28	
	1.2	150 - 320	22 - 32	
	1.6	220 - 380	24 - 34	

Back shielding with Argon or Nitrogen gas or with copper backing support to avoid "back end" rust phenomena.

FT En-MN42-191118

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