

SOLID STAINLESS STEEL CUT LENGTHS AND SPOOLED WIRES



SUGGESTIONS FOR WELDING STAINLESS STEEL

SS FILLER METAL SELECTOR GUIDE

Solid SS 36" CUT LENGTHS (cont.) & SPOOLED WIRES

Stainless Steel Cut Lengths and Spooled Wires are precisely produced to conform to the requirements of AWS A5.9. These products are subjected to rigid quality control throughout the manufacturing process with particular attention given to cleanliness, concentricity and helix of the finished product.

In addition to the Selector Guide, we give below, brief descriptions of the purposes fulfilled by each filler metal.

ER 308: Most frequently used for base metals of similar composition.

ER 308L: Similar usage as the above, but the 0.03% maximum carbon content increases resistance to intergranular corrosion.

ER 308LSi: Similar usage as the above, but the 0.65-1.00% silicon content improves wash and wetting behavior in the gas shielded welding processes.

ER 309: Used for welding similar alloys in wrought or cast form; occasionally used for welding 18-8 base metals when severe corrosion conditions exist; and, at times, welding dissimilar steels.

ER 309L: Similar usage as 309 Bare, but the 0.03% maximum carbon content increases resistance to intergranular corrosion.

ER 309LSi: Similar usage as the above, but the 0.65-1.00% silicon content improves wash and wetting behavior in the gas shielded welding processes.

ER 310: Most frequently used to weld base metals of similar composition.

ER 316: Usually used for welding similar alloys (containing about 2% molybdenum); also for high temperature service applications.

ER 316L: Used principally for welding molybdenum-bearing austenitic alloys containing 0.03% maximum carbon.

ER 316LSi: Similar usage as the above, but the 0.65-1.00% silicon content improves wash and wetting behavior in the gas shielded welding processes.

ER 317L: The alloy content is somewhat higher than for ER316, particularly in molybdenum. The 0.03% maximum carbon content increases resistance to intergranular corrosion due to carbide precipitation. Severe corrosion resistance to sulfuric and sulfurous acids and their salts.

ER 347: A stabilized 18-8, 19-9 alloy that is not subject to intergranular corrosion due to carbide precipitation.

ER410: Used for welding alloys of similar compositions; also for overlays on carbon steels to resist corrosion, erosion or abrasion. Usually requires preheat and postheat treatments.

ER 630: The composition of this filler metal is designed primarily for welding ASTM A564 Type 630 and some other precipitation - hardening stainless steels.

STAINLESS STEEL 36" CUT LENGTHS

PRODUCT and DESCRIPTION	SIZE	STOCK NUMBER	PRICE PER LB
<i>ER308 Stainless Steel</i>	.030	0308TE0	\$13.91
	.035	0308TF0	\$13.26
	.045	0308TH0	\$12.47
	1/16"	0308T30	\$7.39
	3/32"	0308T50	\$6.81
	1/8"	0308T60	\$6.61
	5/32"	0308T70	\$6.60
<i>ER308L Stainless Steel</i>	.030	308LTE0	\$14.36
	.035	308LTF0	\$13.64
	.045	308LTH0	\$12.85
	1/16"	308LT30	\$7.71
	3/32"	308LT50	\$7.09
	1/8"	308LT60	\$6.92
	5/32"	308LT70	\$6.91
<i>ER308L-Si Stainless Steel</i>	1/16"	308ST30	\$8.95
	3/32"	308ST50	\$8.75
	1/8"	308ST60	\$8.25
<i>ER309 Stainless Steel</i>	.035	0309TF0	\$12.86
	.045	0309TH0	\$11.55
	1/16"	0309T30	\$9.66
	3/32"	0309T50	\$8.78
	1/8"	0309T60	\$8.62

PRODUCT and DESCRIPTION	SIZE	STOCK NUMBER	PRICE PER LB
<i>ER309L Stainless Steel</i>	.045	309LTH0	\$13.66
	1/16"	309LT30	\$10.80
	3/32"	309LT50	\$9.28
	1/8"	309LT60	\$8.99
<i>ER310 Stainless Steel</i>	.035	0310TF0	\$16.56
	.045	0310TH0	\$15.60
	1/16"	0310T30	\$13.61
	3/32"	0310T50	\$11.97
	1/8"	0310T60	\$11.67
<i>ER312 Stainless Steel</i>	.045	0312TH0	\$20.89
	1/16"	0312T30	\$13.82
	3/32"	0312T50	\$12.47
	1/8"	0312T60	\$12.27
<i>ER316 Stainless Steel</i>	.035	0316TF0	\$15.15
	.045	0316TH0	\$14.10
	1/16"	0316T30	\$11.80
	3/32"	0316T50	\$10.28
	1/8"	0316T60	\$10.20
<i>ER316L Stainless Steel</i>	5/32"	0316T70	\$10.00
	.045	0316LTH0	\$16.50
	1/16"	0316LT30	\$12.50
	3/32"	0316LT50	\$11.50
1/8"	0316LT60	\$11.25	