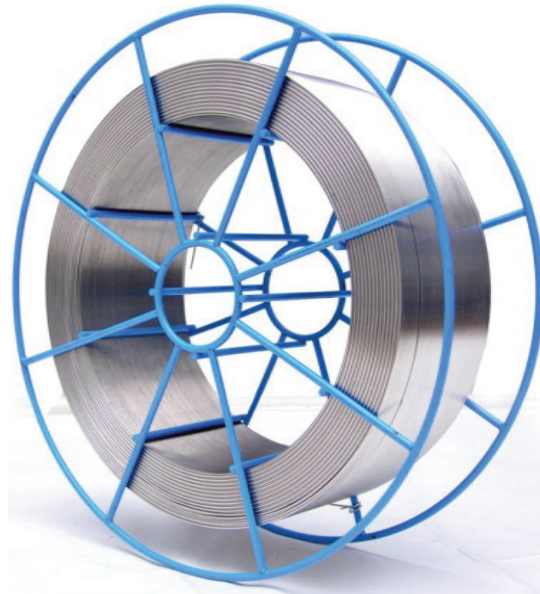


STAINLESS STEEL MIG WIRE



308LSI MIG WIRE

STOCK CODE	SIZE
SMW3808	0.8mm x 15kg
SMW3810	1.0mm x 15kg
SMW3812	1.2mm x 15kg
SMW3816	1.6mm x 15kg
SMW38608	0.8mm x 5.0kg
SMW38610	1.0mm x 5.0kg
SMW38612	1.2mm x 5.0kg

KEY FEATURES

- Suitable for welding 18/8 (304, 308, 308L) austenitic stainless steels.
- Provides superior corrosion and crack resistance.

STANDARDS

- EN ISO 14343 - A:2009 W19 9L
- EN ISO 14343 - B:2009 SS 308L
- AWS A5.9-2012 ER 308L

CHEMICAL COMPOSITION																	
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	Al	Ti	N	Ca	Nb	B	Ce
MIN		1.50	0.65			19.5	10.0	1.50									
MAX	.023	2.40	1.00	.015	.025	20.5	11.0	1.50	0.30	0.20			.060		.050	.003	

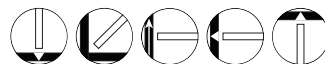
MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Temperature	20°C (-110°C to -196°C)
Yield strength Rp 0.2	390 N/mm ²
Yield strength Rp 1.0	415 N/mm ²
Tensile strength Rm	570 N/mm ²
Elongation A5	35%
Reduction of area Z	40%
Impact energy ISO-V	140J

APPROVAL

TUV
DB
CE
CWB

WELDING POSITIONS



STAINLESS STEEL MIG WIRE

309LSI MIG WIRE

STOCK CODE	SIZE
SMW3908	0.8mm x 15kg
SMW3910	1.0mm x 15kg
SMW3912	1.2mm x 15kg

KEY FEATURES

- Suitable for joining material of similar composition & also dissimilar stainless steels.
- Contains higher Chromium and Nickel. High Silicon levels improve weld pool fluidity.

STANDARDS

- EN ISO 14343 - A:2009
- EN ISO 14343 - B:2009
- AWS A5.9-2012

CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	Al	Ti	N	Ca	Nb	B	Ce
MIN		1.50	0.65	.005		23.0	13.0										
MAX	.020	2.00	1.00	.015	.020	24.0	14.0	0.30	0.20	0.20			.060		.050	.003	

MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Temperature	20°C
Yield strength Rp 0.2	460 N/mm ²
Yield strength Rp 1.0	610 N/mm ²
Tensile strength Rm	570 N/mm ²
Elongation A5	35%
Reduction of area Z	52%
Impact energy ISO-V	117J (102J)

APPROVAL

TUV
DB
CE
CWB

WELDING POSITIONS



316LSI MIG WIRE

STOCK CODE	SIZE
SMW3608	0.8mm x 15kg
SMW3610	1.0mm x 15kg
SMW3612	1.2mm x 15kg
SMW3616	1.6mm x 15kg
SMW36608	0.8mm x 5.0kg
SMW36610	1.0mm x 5.0kg
SMW36612	1.2mm x 5.0kg

KEY FEATURES

- Suitable for joining and cladding 316L joints and overlays.
- Contains considerable ferrite for high crack resistance.

STANDARDS

RW 310

- EN ISO 14343 - A:2009 G 25 20
- EN ISO 14343 - B:2009 SS 310
- AWS A5.9-2012 ER 310

CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	Al	Ti	N	Ca	Nb	B	Ce
MIN		1.50	0.65	.005		18.0	11.0	2.50									
MAX	.030	2.00	1.00	.015	.030	20.0	14.0	3.00	0.30	0.30			.060		.050	.003	

MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Temperature	20°C (-110°C to -196°C)
Yield strength Rp 0.2	450 N/mm ²
Yield strength Rp 1.0	490 N/mm ²
Tensile strength Rm	630 N/mm ²
Elongation A5	33%
Reduction of area Z	46%
Impact energy ISO-V	152

APPROVAL

TUV
DB
CE
CWB

WELDING POSITIONS



STAINLESS STEEL MIG WIRE

310 MIG WIRE

STOCK CODE	SIZE
SMW30608	0.8mm x 5.0kg
SMW30610	1.0mm x 5.0kg
SMW30612	1.2mm x 5.0kg
SMW3008	0.8mm x 15kg
SMW3010	1.0mm x 15kg
SMW3112	1.2mm x 15kg
SMW3116	1.6mm x 15kg

KEY FEATURES

- Suitable for heat-resistant austenitic steels with high 25% Cr / 20% Ni contents.
- Provides a weld deposit that is fully austenitic and therefore requires minimal heat input during welding.

STANDARDS RW 310

- EN ISO 14343 - A:2009 G 25 20
- EN ISO 14343 - B:2009 SS 310
- AWS A5.9-2012 ER 310

CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	Al	Ti	N	Ca	Nb	B	Ce
MIN	.080	1.50	0.30			25.5	20.5										
MAX	.120	2.00	0.60	.015	.015	26.5	21.0	0.30	0.20	0.20			.060		.050	.003	

MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Temperature	20°C
Yield strength Rp 0.2	390 N/mm ²
Yield strength Rp 1.0	590 N/mm ²
Tensile strength Rm	630 N/mm ²
Elongation A5	45%
Impact energy ISO-V	175J

APPROVAL

TUV
DB
CE
CWB

WELDING POSITIONS



347 MIG WIRE

STOCK CODE	SIZE
SMW341608	0.8mm x 5.0kg
SMW341612	1.2mm x 5.0kg
SMW341616	1.6mm x 5.0kg
SMW34108	0.8mm x 15kg
SMW34110	1.0mm x 15kg
SMW34112	1.2mm x 15kg
SMW34116	1.6mm x 15kg

KEY FEATURES

- S347 Niobium stabilized stainless steel wire used for the welding of types 347 & 321 stainless and stainless clad steels.
- The addition reduces inter-granular corrosion in severe operating conditions.

STANDARDS RW 347

- EN ISO 14343 - A:2009 G 19 9 Nb
- EN ISO 14343 - B:2009 SS 347
- AWS A5.9-2012 ER 347

CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	Al	Ti	N	Ca	Nb	B	Ce
MIN	.020	1.20	0.30			19.0	9.00								12xC		
MAX	.060	1.80	0.60	.015	.025	20.0	10.0	0.30	0.30	0.30			.060		.850	.003	

MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Temperature	20°C
Yield strength Rp 0.2	350 N/mm ²
Tensile strength Rm	550 N/mm ²
Elongation A5	25%
Impact energy ISO-V	50J

APPROVAL

TUV
DB
CE
CWB

WELDING POSITIONS





STAINLESS STEEL MIG WIRE

312 MIG WIRE

STOCK CODE	SIZE
SMW3210	1.0mm x 15.0kg
SMW3212	1.2mm x 15.0kg

KEY FEATURES

- Suitable for heat-resistant austenitic steels with high 25% Cr / 20% Ni contents.
- Provides a weld deposit that is fully austenitic and therefore requires minimal heat input during welding.

STANDARDS

- EN ISO 14343 - A:2009
- EN ISO 14343 - B:2009
- AWS A5.9-2012

CHEMICAL COMPOSITION																	
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	Al	Ti	N	Ca	Nb	B	Ce
MIN		1.0	0.30			28.0	8.0										
MAX	.15	2.5	0.65			32.0	21.0	10.5									

MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Temperature	20°C
Yield strength Rp 0.2	550 N/mm2
Tensile strength Rm	750 N/mm2
Elongation A5	25%
Impact energy ISO-V	>80

APPROVAL

TUV
DB
CE
CWB

WELDING POSITIONS



307SI MIG WIRE

STOCK CODE	SIZE
SMW3708	0.8mm x 5.0kg

KEY FEATURES

- Suitable for heat-resistant austenitic steels with high 25% Cr / 20% Ni contents.
- Provides a weld deposit that is fully austenitic and therefore requires minimal heat input during welding.

STANDARDS

- EN ISO 14343 - A:2009
- EN ISO 14343 - B:2009
- AWS A5.9-2012

CHEMICAL COMPOSITION																	
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	Al	Ti	N	Ca	Nb	B	Ce
MIN		4.5	0.65			17.0	7.0										
MAX	.20	7.5	1.0			20.0	10.0										

MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Temperature	20°C
Yield strength Rp 0.2	>350 N/mm2
Tensile strength Rm	560 N/mm2
Elongation A5	>45%
Impact energy ISO-V	>100J

APPROVAL

TUV
DB
CE
CWB

WELDING POSITIONS

