



WELDING WIRE



FILLER METAL

Main grades: chemical composition and standards

AUSTINOX®	Grade	AWS A5.9	C	Si	P max	S max	Cr	Ni	Applications
TIG 307*	1.4370	ER307	0,04-0,14	0,60	0,03	0,03	17,5-20	8-10	Welding of dissimilar stainless steels Limits cracking in thick weldments
MIG 307 Si*	1.4370	ER307Si	0,04-0,14	0,90	0,03	0,03	17,5-20	8-10	
TIG 308L*	1.4316	ER308L	≤ 0,03	0,45	0,03	0,03	19,5-21	9-11	General purpose austenitic 18/10 stainless steel for welding of stainless equipment of similar composition or ferritic 17% stainless steels.
MIG 308LSi*	1.4316	ER308LSi	≤ 0,03	0,90	0,03	0,03	19,5-21	9-11	
TIG 309L*	1.4332	ER309L	≤ 0,03	0,45	0,03	0,03	23-25	12-14	Welding of dissimilar steels or stainless steels and mild steels. Also used in overlays.
MIG 309LSi*	1.4332	ER309LSi	≤ 0,03	0,90	0,03	0,03	23-25	12-14	
TIG/MIG 310	1.4842	ER310	0,08-0,15	0,50	0,03	0,03	25-28	20-22,5	Welding of 25% Cr - 20% Ni stainless steels as well as other heat-resisting high-Cr stainless steels
TIG 316L*	1.4430	ER316L	≤ 0,03	0,45	0,03	0,03	18,0-20	11-14	Austenitic 18/10 with molybdenum stainless steel, used for welding of similar steels as well as type 18/8 – 18/10 stainless steels.
MIG 316LSi*	1.4430	ER316LSi	≤ 0,03	0,90	0,03	0,03	18-20	11-14	
TIG/MIG 318Si	1.4576	ER318	0,06	0,8-0,9	0,03	0,03	18-20	11-14	Nb-stabilized stainless steel for welding of Cr-Ni-Mo and Cr-Ni stabilized or non stabilized stainless steels.
TIG/MIG 347Si	1.4551	ER347Si	0,06	0,8	0,03	0,03	19-21	9-11	Welding of austenitic stainless steels of similar composition, stabilized or not.
TIG/MIG 2209	1.4462	E2209-17	<0,02	0,50	0,03	0,03	23-25	>8,5	Welding of duplex austeno-ferritic stainless steels of similar composition.
	Grade	AWS A5.14	C	Si	Fe	Mo	Cr	Ni	Applications
TIG/MIG 625	2.4831	ERNiCrMo3	<0,03	<0,5	<1	8,5 - 9,5	21-23	Rest.	Welding of Ni-based superalloys such as Inconel 625. Widely used in overlays.
TIG/MIG 6082	2.4806	ER NiCr-3	<0,05	0,5	<2	--	18-22	>67	Welding of Ni-Cr alloys such as Inconel 600 and Incoloy 800



MIG
Ø 0,8 / 1 / 1,2 / 1,6 mm
15 Kg - 5Kg spools

TIG
Ø 1 – 1.2 – 1.6 – 2 – 2.4 – 3.2 mm
5 Kg plastic tubes
1m bare sticks



SADEV INOX – 2, Allée des Faisans – 74600 SEYNOD – France

Tel : 33 – (0) 450 33 70 71 / Fax : 33 – (0) 450 33 70 38 info@sadevinox.com – Web : www.sadevinox.com