



# WELDING WIRE

## FILLER METAL

### Main grades chemical composition and standards



| AUSTINOX®  | Nuance | AWS A5.9     | C         | Si      | P max | S max     | Cr      | Ni      | Applications  |
|------------|--------|--------------|-----------|---------|-------|-----------|---------|---------|---|
| TIG 307    | 1.4370 | ER307        | 0,04-0,14 | 0,65    | 0,03  | 0,03      | 19,5-22 | 8-10,7  | TIG/MIG welding of dissimilar stainless steels. Limits cracking in thick weldments.   |
| MIG 307 Si | 1.4370 | ER307Si      | 0,04-0,14 | 0,65    | 0,03  | 0,03      | 19,5-22 | 8-10,7  |   |
| TIG 308L   | 1.4316 | ER308L       | ≤ 0,03    | 0,65    | 0,03  | 0,03      | 19,5-22 | 9-11    | General purpose austenitic 18/10 stainless steel for welding of stainless equipments. |
| MIG 308LSi | 1.4316 | ER308LSi     | ≤ 0,03    | 0,65-1  | 0,03  | 0,03      | 19,5-22 | 9-11    |   |
| TIG 309L   | 1.4332 | ER309L       | ≤ 0,03    | 0,65    | 0,03  | 0,03      | 23,0-25 | 12-14   | Welding of dissimilar steels (mild steel / stainless steel).                          |
| MIG 309LSi | 1.4332 | ER309LSi     | ≤ 0,03    | 0,65-1  | 0,03  | 0,03      | 23,0-25 | 12-14   |   |
| TIG 310    | 1.4842 | ER310        | 0,08-0,15 | 0,65    | 0,03  | 0,03      | 25-28   | 20-22,5 | Heat resisting stainless steel for TIG/MIG welding of high-Cr stainless steels.       |
| MIG 310    | 1.4842 | ER310        | 0,08-0,15 | 0,65    | 0,03  | 0,03      | 25-28   | 20-22,5 |   |
| TIG 316L   | 1.4430 | ER316L       | ≤ 0,03    | 0,65    | 0,03  | 0,03      | 18-20   | 11-14   | Austenitic 18/10 stainless steel with molybdenum.                                     |
| MIG 316LSi | 1.4430 | ER316LSi     | ≤ 0,03    | 0,65-1  | 0,03  | 0,03      | 18-20   | 11-14   |   |
| TIG 318    | 1.4576 | ER318        | 0,06      | 0,8-0,9 | 0,03  | 0,03      | 18-20   | 11-14   | Welding Niobium or Titanium stabilized stainless grades and alloys.                   |
| MIG 318    | 1.4576 | ER318        | 0,06      | 0,8-0,9 | 0,03  | 0,03      | 18-20   | 11-14   |   |
| TIG 347    | 1.4551 | ER 347       | 0,06      | 0,8     | 0,03  | 0,03      | 19-21   | 9-11    | Welding Ti or Nb stabilized 18/8 stainless types 321 and 347 alloys.                  |
| MIG 347 Si | 1.4551 | ER347Si      | 0,06      | 0,8     | 0,03  | 0,03      | 19-21   | 9-11    |   |
|            | Nuance | AWS A5.4     | C         | Si      | Fe    | Mo        | Cr      | Ni      | Applications  |
| TIG 2209   | 1.4462 | E2209-17     | <0,02     | 0,5     | Rem.  | 3         | 23-25   | >8,5    | Duplex alloy for TIG / MIG welding of ferritic-austenitic duplex steels.              |
| MIG 2209   | 1.4462 | E2209-17     | <0,02     | 0,5     | Rem.  | 3         | 23-25   | >8,5    |   |
|            | Nuance | AWS A5.14    | C         | Si      | Fe    | Mo        | Cr      | Ni      | Applications  |
| TIG 625    | 2.4831 | ER NiCr Mo 3 | <0,03     | <0,5    | <1    | 8,5 - 9,5 | 21-23   | Rest.   | Overlay and TIG/MIG welding of Ni-based superalloys.                                  |
| MIG 625    | 2.4831 | ER NiCr Mo 3 | <0,03     | <0,5    | <1    | 8,5 - 9,5 | 21-23   | Rest.   |   |
| TIG 6082   | 2.4806 | ER NiCr-3    | <0,05     | 0,5     | <2    |           | 18-22   | >67     | For welding Inconel alloy 600 and Incoloy 800.  |
| MIG 6082   | 2.4806 | ER NiCr-3    | <0,05     | 0,5     | <2    |           | 18-22   | >67     |   |



**MIG**  
Ø 0.8 – 1 – 1.2 – 1.6  
15 Kg - 5Kg Basket spools



**TIG**  
Ø 1 – 1.2 – 1.6 – 2 – 2.4 – 3.2 – 4  
Tube 5 Kg - Rods 1 meter

