

Chemical Composition of Stainless Steel Welding Wire

Grade	CHEMICAL COMPOSITION											
	C %	Cr %	Ni %	Mo %	Mn %	Si%	P%	S%	N%	Cu%	Other	Amount
ER308H	0.04-0.08	19.5-22.0	9.0-11.0	0.5	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	-	-
ER308L	0.03	19.5-22.0	9.0-11.0	0.75	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	-	-
ER308LSi	0.03	19.5-22.0	9.0-11.0	0.75	1.0-2.5	0.65-1.00	0.03	0.03	-	0.75	-	-
ER309	0.12	23.0-25.0	12.0-14.0	0.75	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	-	-
ER309L	0.03	23.0-25.0	12.0-14.0	0.75	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	-	-
ER309LSi	0.03	23.0-25.0	12.0-14.0	0.75	1.0-2.5	0.65-1.00	0.03	0.03	-	0.75	-	-
ER309LMo	0.03	23.0-25.0	12.0-14.0	2.0-3.0	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	-	-
ER310	0.08-0.15	25.0-28.0	20.0-22.5	0.75	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	-	-
ER312	0.15	28.0-32.0	8.0-10.5	0.75	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	-	-
ER316	0.08	18.0-20.0	11.0-14.0	2.0-3.0	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	-	-
ER316H	0.04-0.08	18.0-20.0	11.0-14.0	2.0-3.0	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	-	-
ER316L	0.03	18.0-20.0	11.0-14.0	2.0-3.0	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	-	-
ER316LSi	0.03	18.0-20.0	11.0-14.0	2.0-3.0	1.0-2.5	0.65-1.00	0.03	0.03	-	0.75	-	-
ER318	0.08	18.0-20.0	11.0-14.0	2.0-3.0	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	Cb9	8++Cmin/1.0 max
ER321	0.08	18.5-20.5	9.0-10.5	0.75	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	Ti	9++Cmin/1.0 max
ER347	0.08	19.0-21.5	9.0-11.0	0.75	1.0-2.5	0.30-0.65	0.03	0.03	-	0.75	Cb9	10++Cmin/1.0max
ER347Si	0.08	19.0-21.5	9.0-11.0	0.75	1.0-2.5	0.65-1.00	0.03	0.03	-	0.75	Cb9	10++Cmin/1.0max
ER385	0.025	19.5-21.5	24.0-26.0	4.2-5.2	1.0-2.5	0.5	0.02	0.03	-	1.2-2.0	-	-
ER409	0.08	10.5-13.5	0.6	0.5	0.80	0.8	0.03	0.03	-	0.75	Ti	10++Cmin/1.5max
ER409Cb	0.08	10.5-13.5	0.6	0.5	0.80	1.00	0.04	0.03	-	0.75	Cb9	10++Cmin/0.75max

ER410	0.12	11.5-13.5	0.6	0.75	0.60	0.5	0.03	0.03	-	0.75	-	-
ER410 Ni Mo	0.06	11.0-12.5	4.0-5.0	0.4-0.7	0.60	0.5	0.03	0.03	-	0.75	-	-
ER420	0.25-0.40	12.0-14.0	0.6	0.75	0.60	0.5	0.03	0.03	-	0.75	-	-
ER430	0.1	15.5-17.0	0.6	0.75	0.60	0.5	0.03	0.03	-	0.75	-	-
ER307	0.04-0.14	19.5-22.0	8.0-10.7	0.5-1.5	3.3-4.75	0.3-0.65	0.03	0.03	-	0.75	-	-
ER2209	0.03	21.5-23.5	7.5-9.5	2.5-3.5	0.50-2.00	0.90	0.03	0.03	0.08-0.20	0.75	-	-
ER2594	0.03	24.0-27.0	8.0-10.5	2.5-4.5	2.50	1.00	0.03	0.02	0.20-0.30	1.50	-	-
308LW(Mod .)	0.02	19.80-20.50	9.80-10.60	--	1.0-2.5	0.20	0.015	0.02	--	--	--	-

* Single Values shown are maximum percentages.