JIS Z3321 Y308
AWS A5.9 ER308
DIN 8556-SG 1.4302

MS M-308 Solid Wires for Stainless Steel

Applications

Suitable for 18%Cr-8%Ni,19%Cr-9%N and 20%Cr10%N stainless steel.
Used to weld base metals of similar composition inparticalar type 304

Brand Name	MS M-308								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.08	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	9.0-11.0	19.5-22.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm²								
0.2% Offset strength	≥ 225 N/mm²								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196° C 49 J								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y308L
AWS A5.9 ER308L
DIN 8556-SG 1.4316

MS M-308L Solid Wires for Stainless Steel

Applications

Suitable for low carbon18%Cr-8%Ni stainless steel. This filler metal reduces the possibility of intergranular carbide precipitation.

Brand Name	MS M-308L								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.030	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	9.0 - 11.0	19.5 - 22.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 510 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196° C 59 J								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y308LSi
AWS A5.9 ER308LSi
DIN 8556-SG 1.4316

MS M-308LSi Solid Wires for Stainless Steel

Applications

Suitable for low carbon18%Cr-8%Ni stainless steel The arc stability, bead width and blow hole resistibility is good because of high silicon. It can be applied to multi-layer welding.

Brand Name	MS M-308LSi								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.030	≤ 0.65 -1.00	1.0- 2.5	≤ 0.03	≤ 0.03	9.0 - 11.0	19.5 - 22.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 510 N/mm²								
0.2% Offset strength	≥ 205 N/mm²								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196° C 59 J								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

MS M-308N2 **Solid Wires for Stainless Steel**

Applications Suitable for welding of 304N2 stainless steel

Brand Name	**MS M-308N2**								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	N
	≤ 0.10	≤ 0.90	1.0-4.0	≤ 0.03	≤ 0.03	7.0 - 11.0	20.0-25.0	-	0.12-0.30
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y309
AWS A5.9 ER309
DIN 8556-SG 1.4829

MS M-309 Solid Wires for Stainless Steel

Applications

Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals, such as joining type 304 to carbon steel.

Brand Name	MS M-309								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.12	≤ 0.65	1.0 - 2.5	≤ 0.03	≤ 0.03	12.0 - 14.0	23.0 - 25.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y309L
AWS A5.9 ER309L
DIN 8556-SG 1.4332

MS M-309L Solid Wires for Stainless Steel

Applications

Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals. Usage as MS M-309, but the 0.03% maximun carbon increases resistance to intergranular corrosion.

Brand Name	**MS M-309L**								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.030	≤ 0.65	1.0 - 2.5	≤ 0.03	≤ 0.03	12.0 - 14.0	23.0-25.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 510 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS -
AWS A5.9 ER309LSi
DIN 8556-SG 1.4332

MS M-309LSi Solid Wires for Stainless Steel

Applications

Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals. Usage as MS M-309L, but the 0.65-1.0% silicon content improves wetting behavior in the gas shielded welding process.

Brand Name	MS M-309LSi								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.030	≤ 0.65 1.00	1.0-2.5	≤ 0.03	≤ 0.03	12.0-14.0	23.0-25.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 510 N/mm²								
0.2% Offset strength	≥ 205 N/mm²								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196° C 49 J								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y309Mo
AWS A5.9 ER309Mo
DIN 8556-SG 1.4459

MS M-309Mo Solid Wires for Stainless Steel

Applications

Suitable for welding of stainless steel to carbon steel and root runs in cladding.Addition 2.03.0%Mo to increase its pitting corrosion resistance in halide-containing environments.

Brand Name	MS M-309Mo								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.12	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	12.0 - 14.0	23.0-25.0	2.0-3.0	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y310
AWS A5.9 ER310
DIN 8556-SG 1.4842

MS M-310 Solid Wires for Stainless Steel

Applications

Suitable for welding of similar composition (26.5%Cr21%Ni) or clad part of 18%Cr-8%Ni stainless steel.Owing to the high contents of alloying elements,ductility maintained in welding of carbon steel where deposited metal is diluted by base metal steel.

Brand Name	MS M-310								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.15	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	20.0-22.5	25.0-28.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm²								
0.2% Offset strength	≥ 225 N/mm²								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250A	170-300A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

Gas Metal Arc Welding

MS M-310S **Solid Wires for Stainless Steel**

Applications Suitable for welding of 310S stainless steel

Brand Name	**MS M-310S**								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.08	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	20.0 - 22.5	25.0-28.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250A	170-300A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y312
AWS A5.9 ER312
DIN 8556-SG 1.4337

MS M-312 Solid Wires for Stainless Steel

Applications

Suitable for welding of dissimilar metals such as stainless steel, carbon steel and low alloy steel. MS M-312 has excellent usability and weldability.
Owing to the austenite structure containing large cotents of ferrite,MS M-312 has good crack resistibility steel.

Brand Name	MS M-312								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.15	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	8.0-10.5	28.0 - 32.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250A	170-300A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y316
AWS A5.9 ER316
DIN 8556-SG 1.4403

MS M-316 Solid Wires for Stainless Steel

Applications

Suitable for welding of 18%Cr-12%Ni-2%Mo stainless steel, 13%Cr steel,17%Cr steel and high toughness steel when postheating is not recommended. Use for welding between dissimilar metal like carbon steeland stainless steel.

Brand Name	**MS M-316**								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.08	≤ 0.65	1.0 - 2.5	≤ 0.03	≤ 0.03	11.0-14.0	18.0-20.0	2.0-3.0	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 30 %								
Impact test	2mm Vnotch Impact value at -196° C 39 J								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6mm
	80-180A	120-200A	140-250A	170-300A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y316L
AWS A5.9 ER316L
DIN 8556-SG 1.4430

MS M-316L Solid Wires for Stainless Steel

Applications

Suitable for welding of extra-low carbon 18%Cr-12% Ni 2%Mo stainless steel.
In this filler metal reduces the possibility of intergranular choromium carbide precipitation.

Brand Name	MS M-316L								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.030	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	11.0-14.0	18.0-20.0	2.0-3.0	-
Mechanical property of deposited metal									
Tensile strength	≥ 510 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196° C 49 J								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250A	170-300A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

Gas Metal Arc Welding

MS M-316LSi Solid Wires for Stainless Steel

Applications

Suitable for welding of extra-low carbon 18%Cr-12%Ni-2%Mo stainless steel. Usage as MS M-316L, but the 0.65-1.0% silicon content improves wetting behavior in the gas shielded welding process.

Brand Name	MS M-316LSi								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.030	0.65-1.00	1.0-2.5	≤ 0.03	≤ 0.03	11.0-14.0	18.0-20.0	2.0-3.0	-
Mechanical property of deposited metal									
Tensile strength	≥ 510 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196° C 49 J								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250A	170-300A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y16-8-2
AWS A5.9 ER16-8-2
DIN -

MS M-16-8-2 Solid Wires for Stainless Steel

Applications

Suitable for type 16-8-2,316 and 347 for high-pressure high-temperature piping systems.The deposit also has good hot-ductility properties.

Brand Name	MS M-16-8-2								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.10	≤ 0.65	1.0 - 2.5	≤ 0.03	≤ 0.03	7.5-9.5	14.5 - 16.5	1.0 - 2.0	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250A	170-300A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

MS M-316J1L Solid Wires for Stainless Steel

Applications Suitable for welding of 316J1L stainless steel.

Brand Name	MS M-316J1L								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
	0.030	≤ 0.65	1.0 - 2.5	≤ 0.03	≤ 0.03	11.0 - 14.0	18.0 - 20.0	2.0 - 3.0	1.0- 2.5
Mechanical property of deposited metal									
Tensile strength	≥ 510 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y317
AWS A5.9 ER317
DIN 8556-SG 1.4440

MS M-317 Solid Wires for Stainless Steel

Applications

Suitable for welding of 317 stainless steel is utilized in severely corrosive environments where crevie and pitting corrosion are of concern

Brand Name	MS M-317								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.08	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	13.0-15.0	18.5 20.5	3.0 4.0	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y317L
AWS A5.9 ER317L
DIN 8556-SG 1.4440

MS M-317L Solid Wires for Stainless Steel

Applications

Suitable for welding of 317L stainless steel. Usde same as MS M-317 and reduces the possibility of intergranular carbide precipitation

Brand Name	MS M-317L								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.030	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	13.0 - 15.0	18.5-20.5	3.0-4.0	-
Mechanical property of deposited metal									
Tensile strength	≥ 510 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

MS M-321 Solid Wires for Stainless Steel

Applications

Suitable for welding of 321 stainless steel. With Titanium added.
The Titanium acts in the same way Nb(Cb) in type 347 and thus increasing resistance to intergranular corrosion

Brand Name	MS M-321								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	Ti
	≤ 0.08	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	9.0-10.5	18.5-20.5	-	9xC-1.0
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y347
AWS A5.9 ER347
DIN 8556-SG 1.4551

MS M-347 Solid Wires for Stainless Steel

Applications

Suitable for welding of 316,316L and 318 stainless steel. With Nb(Cb) added as a stabilizer and reduces the possibility of intergraular chromium carbide precipitation

Brand Name	MS M-347								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	Nb
	≤ 0.08	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	9.0-11.0	19.0-21.5	-	10xC -1.0
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

MS M-347L Solid Wires for Stainless Steel

Applications

Suitable for welding of 316,316L and 318 stainless steel. Low carbon content than MS M-347,with Nb(Cb) added as a stabilizer and reduces the possibility of intergranular chromium carbide precipitation

Brand Name	MS M-347L								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	Nb
	≤ 0.030	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	9.0-11.0	19.0-21.5	-	10xc-1.0
Mechanical property of deposited metal									
Tensile strength	≥ 510 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y410
AWS A5.9 ER410
DIN 8556-SG 1.4009

MS M-410 Solid Wires for Stainless Steel

Applications

Suitable for welding of 405,410,410S stainless steel is an air-hardening steel. Preheat and posheat trealments are required to achieve welds of adequate ductility for many engineering purposes.

Brand Name	MS M-410								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.12	≤ 0.50	≤ 0.6	≤ 0.03	≤ 0.03	≤ 0.6	11.5-13.5	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 450 N/mm^2								
0.2% Offset strength	-								
Elongation	≥ 20 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

JIS Z3321 Y430
AWS A5.9 ER430
DIN 8556-SG 1.4015

MS M-430 Solid Wires for Stainless Steel

Applications

Suitable for welding 430,405 stainless steel. The MS M-430 classification usually requires preheating and postweld heat treatment

Brand Name	MS M-430								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.10	≤ 0.50	≤ 0.6	≤ 0.03	≤ 0.03	≤ 0.6	15.5-17.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 450 N/mm²								
0.2% Offset strength	-								
Elongation	≥ 20 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				

MS M-430MR Solid Wires for Stainless Steel

Applications: Suitable for 13-17%Cr type stainless steel for thin plate in muffler welding

Brand Name	MS M-430MR								
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	Nb
	≤ 0.030	≤ 0.50	≤ 0.6	≤ 0.03	≤ 0.03	≤ 0.6	15.5-18.0	-	0.4-0.8
Mechanical property of deposited metal									
Tensile strength	≥ 450 N/mm^2								
0.2% Offset strength	-								
Elongation	≥ 20 %								
Impact test	NA								

Welding position	Horizontal/Flat position				
Welding polarity	DC-EP				
Shielding gas	98%Ar - 2%O_2				
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm
	80-180A	120-200A	140-250 A	170-300 A	200-350A
Packing	12.50 kgs standard other packing weight can be provided upon request.				