Gas Tungsten Arc Welding

MS T-308 Filler Rod for Stainless Steel

Applications

Suitable for 18%Cr-8%Ni stainless steel. Used to weld base metals of similar composition inparticalar type 304

Brand Name	MS T-308								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Chemical composition of lenght	1000 mm Standard or 950 mm Upon requested.								
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	≥ 540 N/mm²								
0.2% Offset strength	≥ 225 N/mm²								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196 °C 39J								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

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

MS T-308L Filler Rod 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 T-308L								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Chemical composition of lenght	1000 mm Standard or 950 mm Upon requested.								
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	≥ 500 N/mm²								
0.2% Offset strength	≥ 205 N/mm²								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196 °C 39J								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

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

MS T-308LSi **Filler Rod 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 T-308LSi**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Chemical composition of lenght	1000 mm Standard or 950 mm Upon requested.								
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	≥ 500 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

MS T-308N2 **Filler Rod for Stainless Steel**

Applications Suitable for welding of 304N2 stainless steel

Brand Name	**MS T-308N2**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Chemical composition of lenght	1000 mm Standard or 950 mm Upon requested.								
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	≥ 540 N/mm²								
0.2% Offset strength	≥ 225 N/mm²								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

MS T-309 Filler Rod 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 T-309								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Chemical composition of lenght	1000 mm Standard or 950 mm Upon requested.								
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	≥ 540 N/mm²								
0.2% Offset strength	≥ 225 N/mm²								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

MS T-309L Filler Rod 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% maximum carbon increases to intergranular corrosion.

Brand Name	MS T-309L								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Chemical composition of lenght	1000 mm Standard or 950 mm Upon requested.								
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.030	≤ 0.65	1.0-2.50	≤ 0.03	≤ 0.03	12.0-14.0	23.0 25.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 500 N/mm²								
0.2% Offset strength	≥ 205 N/mm²								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -0° C 88J								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm.v
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

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

MS T-309LSi Filler Rod 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 T-309LSi								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Chemical composition of lenght	1000 mm Standard or 950 mm Upon requested.								
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	≥ 540 N/mm²								
0.2% Offset strength	≥ 225 N/mm²								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -0 °C 80J								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

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

MS T-309Mo Filler Rod for Stainless Steel

Applications

Suitable for welding of stainless steel to carbon steel and root runs in cladding. Addition 2.0-3.0%Mo to increase its pitting corrosion resistance in halide-containing environments.

Brand Name	MS T-309Mo								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Chemical composition of lenght	1000 mm Standard or 950 mm Upon requested.								
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	≥ 540 N/mm²								
0.2% Offset strength	≥ 225 N/mm²								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

MS T-310 **Filler Rod for Stainless Steel**

Applications

Suitable for welding of similar composition (26.5%Cr-21%Ni) or clad part of a18%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 T-310**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	> 540 N/mm²								
0.2% Offset strength	> 225 N/mm²								
Elongation	> 35 %								
Impact test	NA								

Welding position	All position		Welding polarity
DC-EN	Shielding gas		Ar
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
		Packing	
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

JIS Z3321 Y310S
AWS A5.9 ER310S
DIN 8556-SG 1.4842

MS T-310S **Filler Rod for Stainless Steel**

Applications Suitable for welding of 310S stainless steel.

Brand Name	**MS T-310S**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	> 540 N/mm²								
0.2% Offset strength	> 225 N/mm²								
Elongation	> 35 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

MS T-312 **Filler Rod 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 contents of ferrite, MS M-312 has good crack resistibility.

Brand Name	**MS T-312**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 540 N/mm²								
0.2% Offset strength	≥ 225 N/mm²								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

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

MS T-316 **Filler Rod 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 steel and stainless steel

Brand Name	**MS T-316**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 540 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	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

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

MS T-316L **Filler Rod 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 T-316L**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 500 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196° C 39 J								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

JIS -
AWS A5.9 ER316LSi
DIN 8556-SG 1.4430

MS T-316LSi **Filler Rod 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 T-316LSi**								
Representative of diameter (mm.)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.030	0.65-1.0	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	≥ 500 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

MS T-16-8-2 **Filler Rod 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 which offer greater freedom from weld or creter cracking even under restraint condition.

Brand Name	**MS T-16-8-2**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 540 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

MS T-316J1L **Filler Rod for Stainless Steel**

Applications Suitable for welding of 316J1L stainless steel.

Brand Name	**MS T-316J1L**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 540 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 35 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

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

MS T-317 **Filler Rod 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 T-317**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 540 N/mm²								
0.2% Offset strength	≥ 225 N/mm²								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

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

MS T-317L **Filler Rod for Stainless Steel**

Applications

Suitable for welding of 317L stainless steel. Used same as MS T-317 and reduces the possibility of intergranular carbide precipitation and increases the resistance to intergranular corrosion.

Brand Name	**MS T-317L**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 500 N/mm^2								
0.2% Offset strength	≥ 205 N/mm^2								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

MS T-321 **Filler Rod 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 T-321**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 540 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

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

MS T-347 **Filler Rod 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 T-347**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 540 N/mm^2								
0.2% Offset strength	≥ 225 N/mm^2								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

JIS Z3321 Y347L
AWS A5.9 ER347L
DIN 8556-SG 1.4551

MS T-347L **Filler Rod for Stainless Steel**

Applications

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

Brand Name	**MS T-347L**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 500 N/mm²								
0.2% Offset strength	≥ 205 N/mm²								
Elongation	≥ 30 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

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

MS T-410 **Filler Rod for Stainless Steel**

Applications

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

Brand Name	**MS T-410**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≤ 0.75	-
Mechanical property of deposited metal									
Tensile strength	≥ 450 N/mm^2								
0.2% Offset strength	-								
Elongation	≥ 20 %								
Impact test	2mm Vnotch Impact value at 20° C 210J								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

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

MS T-430 **Filler Rod for Stainless Steel**

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

Brand Name	**MS T-430**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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/mm^2								
0.2% Offset strength	-								
Elongation	≥ 20 %								
Impact test	NA								

Welding position	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		

Gas Tungsten Arc Welding

MS T-430MR **Filler Rod for Stainless Steel**

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

Brand Name	**MS T-430MR**								
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	All position		
Welding polarity	DC-EN		
Shielding gas	Ar		
Welding current	Dia. 1.2 mm	Dia. 1.6 mm	Dia. 2.4 mm
	30-80 A	40-120 A	50-150 A
Packing			
Inner case weight (kg)	5.00		