

## Submerged Arc Wires for Stainless Steel

Products	Classification		Chemical properties (wt %)			
	AWS	JIS	Ni	Cr	Mo	Nb
KW-308	ER308	S308	10.32	21.23	—	—
KW-308L	ER308L	S308L	10.45	22.41	—	—
KW-309	ER309	S309	13.24	24.63	—	—
KW-309L	ER309L	S309L	13.51	24.43	—	—
KW-309MoL	ER309LMo	S309Mo	13.45	24.12	2.31	—
KW-316	ER316	S316	13.27	19.01	2.22	—
KW-316L	ER316L	S316L	13.42	19.22	2.31	—
KW-317L	ER317L	S317L	13.55	19.53	3.45	—
KW-347	ER347	S347	10.43	20.23	—	0.65
KW-410	ER410	S410	0.04	12.65	—	—

Chemical properties (wt %)			Diameter (mm)	Applications
C	Si	Mn		
0.061	0.34	1.82	2.0,2.4,3.2,4.0,4.8	It is suitable for welding AISI 304 and 308.
0.021	0.35	1.65	2.0,2.4,3.2,4.0,4.8	It is suitable for welding AISI 304L, 308L and 321.
0.065	0.33	1.75	2.0,2.4,3.2,4.0,4.8	Ideal for joining carbon steel to stainless steel.
0.019	0.34	1.56	2.0,2.4,3.2,4.0,4.8	Ideal for joining carbon steel to low carbon stainless steel.
0.023	0.29	1.67	2.0,2.4,3.2,4.0,4.8	Ideal for joining carbon steel to stainless steel.
0.067	0.33	1.88	2.0,2.4,3.2,4.0,4.8	Ideal for welding AISI 316.
0.022	0.28	1.52	2.0,2.4,3.2,4.0,4.8	Ideal for welding AISI 316L.
0.021	0.37	1.77	2.0,2.4,3.2,4.0,4.8	Ideal for welding AISI 317L.
0.055	0.35	1.45	2.0,2.4,3.2,4.0,4.8	Ideal for welding AISI 304L, 308L and 321.
0.077	0.23	0.51	2.0,2.4,3.2,4.0,4.8	Ideal for welding AISI 410.