



MIGINIOX

SOLID STAINLESS STEEL WIRES FOR MIG WELDING

| MIGINOX FOR MIG WELDING | | Typical Wire Chemistry | | | | | | | Typical Weld Metal Properties with 100% Ar + 2%O ₂ gas shielding | | | | Sizes (Dia.mm) : |
|-----------------------------------|-----------------------|------------------------|------|------|------|------|------|------|---|------------|------------|---------------|--|
| | | C | Mn | Si | Cr | Ni | Mo | Nb | Typical mechanical properties of All-weld metal in As-welded condition | | | | |
| | | | | | | | | | U.T.S Mpa | %E (4d) | CVN Impact | | |
| BRAND | AWS Classification | | | | | | | | | | | Temp deg C | J |
| MIGINOX 308 | ER 308 | 0.045 | 1.65 | 0.45 | 20.0 | 10.0 | — | — | 650 | 36 | -60 | 45 | 0.8, |
| MIGINOX 308L | ER 308L | 0.022 | 1.65 | 0.45 | 20.0 | 10.0 | — | — | 620 | 40 | -196 | 50 | 1.0, |
| MIGINOX 347 | ER 347 | 0.04 | 1.55 | 0.45 | 20.0 | 10.0 | — | 0.50 | 640 | 37 | -60 | 35 | 1.2, |
| MIGINOX 316 | ER 316 | 0.045 | 1.55 | 0.45 | 19.0 | 12.0 | 2.50 | — | 650 | 34 | -60 | 40 | 1.6, |
| MIGINOX 316L | ER 316L | 0.025 | 1.55 | 0.45 | 19.0 | 12.0 | 2.50 | — | 620 | 38 | -196 | 45 | 2.0 |
| MIGINOX 309 | ER 309 | 0.04 | 1.50 | 0.45 | 24.0 | 13.0 | — | — | 620 | 38 | -60 | 60 | |
| MIGINOX 309L | ER 309L | 0.026 | 1.55 | 0.5 | 24.0 | 13.0 | — | — | 600 | 40 | -60 | 35 | |
| MIGINOX 309Mo | ER 309Mo | 0.04 | 1.55 | 0.48 | 24.0 | 13.0 | 2.50 | — | 640 | 38 | -60 | 75 | |
| MIGINOX 310 | ER 310 | 0.10 | 1.55 | 0.48 | 26.5 | 21.0 | — | — | 590 | 43 | — | — | (In 15 Kg. Spools) |
| MIGINOX 312 | ER 312 | 0.10 | 1.55 | 0.50 | 30.0 | 9.5 | — | — | 680 | 23 | — | — | Note : The properties mentioned will vary with the type of shielding gas used. |
| MIGINOX 410 | ER 410 | 0.08 | 0.50 | 0.40 | 12.5 | — | — | — | 530* | 23* | — | — | |
| MIGINOX 430 | ER 430 | 0.06 | 0.50 | 0.40 | 16.5 | — | — | — | 550** | 23** | — | — | |

Note: The properties mentioned above will vary with type of shielding gas used

*-After PWHT of 1 hour at 745 deg C, furnace cooled to 315 deg C and then cooled in still air.

** - After PWHT of 2 hours at 775 deg C, furnace cooled to 590 deg C and then cooled in still air.