



SUBINOX

SOLID STAINLESS STEEL WIRES FOR SAW WELDING

| SUBINOX FOR SAW WELDING | | Typical Wire Chemistry | | | | | | | Typical Weld Metal Properties with Automelt S 76 Flux | | | | | | | | | | |
|------------------------------------|-----------------------|------------------------|------|------|-------|-------|------|------|---|------|------|-------|-------|---------------|---|--------------|------------|------------|----|
| BRAND | AWS Classification | C | Mn | Si | Cr | Ni | Mo | Nb | Typical Wire Chemistry | | | | | | Typical mechanical properties of All-weld metal in As-welded condition | | | | |
| | | | | | | | | | C | Mn | Si | Cr | Ni | Mo | Nb | U.T.S Mpa | %E (4d) | CVN Impact | |
| | | | | | | | | | | | | | | Temp deg C | J | | | | |
| SUBINOX 308 | ER 308 | 0.045 | 1.60 | 0.40 | 20.00 | 10.00 | — | — | 0.046 | 1.65 | 0.45 | 19.70 | 9.80 | — | — | 650 | 36 | -60 | 45 |
| SUBINOX 308L | ER 308L | 0.022 | 1.60 | 0.40 | 20.00 | 10.00 | — | — | 0.024 | 1.62 | 0.42 | 19.70 | 9.80 | — | — | 620 | 40 | -196 | 55 |
| SUBINOX 347 | ER 347 | 0.04 | 1.50 | 0.40 | 20.00 | 10.00 | — | 0.50 | 0.042 | 1.54 | 0.44 | 19.65 | 9.80 | — | 0.48 | 640 | 37 | -60 | 40 |
| SUBINOX 316 | ER 316 | 0.045 | 1.50 | 0.40 | 19.00 | 12.00 | 2.50 | — | 0.046 | 1.53 | 0.45 | 18.65 | 11.75 | 2.40 | — | 650 | 34 | -60 | 40 |
| SUBINOX 316L | ER 316L | 0.025 | 1.50 | 0.40 | 19.00 | 12.00 | 2.50 | — | 0.024 | 1.51 | 0.42 | 18.65 | 11.75 | 2.40 | — | 620 | 38 | -196 | 45 |
| SUBINOX 309 | ER 309 | 0.04 | 1.50 | 0.45 | 24.00 | 13.00 | — | — | 0.042 | 1.54 | 0.50 | 23.70 | 12.75 | — | — | 620 | 38 | -60 | 65 |
| SUBINOX 309L | ER 309L | 0.026 | 1.50 | 0.45 | 24.00 | 13.00 | — | — | 0.027 | 1.54 | 0.48 | 23.70 | 12.75 | — | — | 600 | 40 | -60 | 90 |
| SUBINOX 309Mo | ER 309Mo | 0.04 | 1.50 | 0.45 | 24.00 | 13.00 | 2.50 | — | 0.043 | 1.54 | 0.48 | 23.70 | 12.75 | 2.40 | — | 640 | 38 | -60 | 80 |
| SUBINOX 310 | ER 310 | 0.10 | 1.50 | 0.45 | 26.50 | 21.00 | — | — | 0.12 | 1.53 | 0.44 | 26.15 | 20.80 | — | — | 590 | 43 | — | — |
| SUBINOX 312 | ER 312 | 0.10 | 1.55 | 0.50 | 30.0 | 9.5 | — | — | — | — | — | — | — | — | — | 680 | 23 | — | — |
| SUBINOX 410 | ER 410 | 0.08 | 0.45 | 0.35 | 12.50 | — | — | — | 0.10 | 0.46 | 0.38 | 12.20 | — | — | — | 530* | 23* | — | — |
| SUBINOX 430 | ER 430 | 0.06 | 0.45 | 0.35 | 16.50 | — | — | — | 0.08 | 0.46 | 0.38 | 16.20 | — | — | — | 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 595 deg C and then cooled in still air.