

# STAINLESS MIG WIRE

**308L - PowerWeld 308L** is used for TIG and MIG welding of unstabilized steels such as types 301, 302, 304, 305, 308. The average carbon content of 0.02% produces a weld deposit with good resistance against intergranular corrosion caused by carbide precipitation. This filler metal is the most popular grade among stainless steels, used for general purpose applications.

**309L - PowerWeld 309L** is used for the welding of similar alloys in wrought or cast form. It is mostly used for welding dissimilar materials such as mild steel to stainless steel, as well as for a barrier layer in stainless overlays. It has low carbon content of less than 0.03% reduces the possibility of intergranular corrosion. For some applications, welding of straight chromium steels.

**316L - PowerWeld 316L** is used to weld wrought and cast forms of similar composition, as well as low carbon molybdenum-bearing austenitic alloys. The lower ferrite level of this normal composition reduces the rate of corrosion in certain media and is suitable for use at cryogenic temperatures. The presence of molybdenum increases its creep resistance at elevated temperatures.

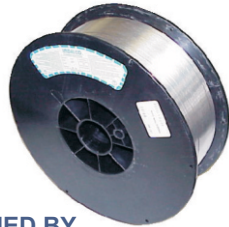
All grades meet specification ASME SFA5.9 and are certified by CWB to AWS A5.9

Suggested Welding Parameters for Stainless Steel Welding

MIG Welding: DCEP

Shielding Gas: 98% Argon + 2% Oxygen  
Gas Flow: 30 to 50 CFH

Size	Amperage	Voltage
.023"	35 - 70	21 - 26
.030"	50 - 100	24 - 28
.035"	160 - 210	26 - 29
.045"	180 - 250	28 - 32



Diameter	Spool Size	308L	309L	316L
.024" (0.6mm)	2# (0.9kg) spool	308L02402	309L02402	316L02402
	10# (4.5kg) spool	308L02410	309L02410	316L02410
	33# (15kg) spool	308L02433	309L02433	316L02433
.030" (0.8mm)	2# (0.9kg) spool	308L03002	309L03002	316L03002
	10# (4.5kg) spool	308L03010	309L03010	316L03010
	33# (15kg) spool	308L03033	309L03033	316L03033
.035" (0.9mm)	2# (0.9kg) spool	308L03502	309L03502	316L03502
	10# (4.5kg) spool	308L03510	309L03510	316L03510
	33# (15kg) spool	308L03533	309L03533	316L03533
.045" (1.2mm)	2# (0.9kg) spool	308L04502	309L04502	316L04502
	10# (4.5kg) spool	308L04510	309L04510	316L04510
	33# (15kg) spool	308L04533	309L04533	316L04533

# STAINLESS TIG WIRE



TIG Welding: DCEN  
Shielding Gas: 100% Argon  
Gas Flow: 30 to 40 CFH



Size	Amperage	Voltage
.035"	60 - 90	12 - 15
.045"	80 - 110	13 - 16
1/16"	90 - 130	14 - 18
3/32"	120 - 175	15 - 20
1/8"	150 - 220	15 - 20

Diameter	308L	309L	316L
.035" (0.9mm)	ER308L-035	ER309L-035	ER316L-035
.045" (1.2mm)	ER308L-045	ER309L-045	ER316L-045
1/16" (1.6mm)	ER308L-116	ER309L-116	ER316L-116
3/32" (2.4mm)	ER308L-332	ER309L-332	ER316L-332
1/8" (3.2mm)	ER308L-18	ER309L-18	ER316L-18

Each TIG rod is stamped with grade for identification.

PACKAGING: 10 pound (4.5kg) tubes

# STAINLESS ELECTRODES



PRODUCT DESCRIPTION	DIAMETER / SIZE	ITEM #
E308L-18 STAINLESS STEEL ELECTRODE AWS A5.4 ASME SFA5.4 CLASS E308L-16 AC/DC	3/32 - 2.5mm X 300mm 1/8 - 3.2mm X 350mm 5/32 - 4.0mm X 350mm	PW308L25 PW308L32 PW308L40
E309L-18 STAINLESS STEEL ELECTRODE AWS A5.4 ASME SFA5.4 CLASS E309L-16 AC/DC	3/32 - 2.5mm X 300mm 1/8 - 3.2mm X 350mm 5/32 - 4.0mm X 350mm	PW309L25 PW309L32 PW309L40
E316L-18 STAINLESS STEEL ELECTRODE AWS A5.4 ASME SFA5.4 CLASS E316L-16 AC/DC	3/32 - 2.5mm X 300mm 1/8 - 3.2mm X 350mm 5/32 - 4.0mm X 350mm	PW316L25 PW316L32 PW316L40

PACKAGING: 2 kg (4.4 lbs) boxes, 20 kg (44 lbs) per carton