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.

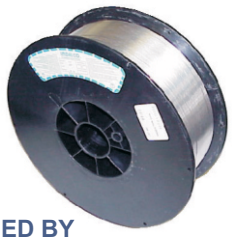
316L - PowerWeld 316L is used to weld wrought and cast forms of similar composition, as well as low carbon molybdenum-bearing austenitic alloys. The lower ferrite level of this normal composition reduces the rate of corrosion in certain media and is suitable for use at cryogenic temperatures. The presence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



CERTIFIED BY CANADIAN WELDING BUREAU

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

CERTIFIED BY CANADIAN WELDING BUREAU

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

CERTIFIED BY CANADIAN WELDING BUREAU

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