Igniting Solutions™

D & H INDIA LIMITED

Formerly 'D & H Welding Electrodes (India) Ltd'

TIG MIG Stainless Steel Filler Wires

High Efficiency - Optimum Productivity

X-ray Quality Sound Weld Metal

TIG MIG Stainless Steel Filler Wire

BRAND NAME	AWS CLASSIFICATION	CHEMICAL COMPOSITION (%)										MECHANICAL PROPERTIES ALL WELD METAL) (MIN -VALUES)	
		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Others	UTS	Elongation
SUPER TIG 308	ER 308	0.08 Max.	1.0-2.5	0.30-0.65	0.03 Max.	0.03 Max.	19.5-22.0	9.0-11.0	0.75 Max.	0.75 Max.	-	550	35
SUPER TIG 308L	ER 308L	0.03 Max.	1.0-2.5	0.30-0.65	0.03 Max.	0.03 Max.	19.5-22.0	9.0-11.0	0.75 Max.	0.75 Max.	-	520	35
SUPER TIG 309	ER 309	0.12 Max.	1.0-2.5	0.30-0.65	0.03 Max.	0.03 Max.	23.0-25.0	12.0-14.0	0.75 Max.	0.75 Max.	-	550	30
SUPER TIG 309L	ER 309L	0.03 Max.	1.0-2.5	0.30-0.65	0.03 Max.	0.03 Max.	23.0-25.0	12.0-14.0	0.75 Max.	0.75 Max.	-	520	30
SUPER TIG 316	ER 316	0.08 Max.	1.0-2.5	0.30-0.65	0.03 Max.	0.03 Max.	18.0-20.0	11.0-14.0	2.0-3.0	0.75Max	-	520	30
SUPER TIG 316L	ER 316L	0.03 Max.	1.0-2.5	0.30-0.65	0.03 Max.	0.03 Max.	18.0-20.0	11.0-14.0	2.0-3.0	0.75 Max.	-	490	40
SUPER TIG 310	ER 310	0.08-0.15	1.0-2.5	0.30-0.65	0.03 Max.	0.03 Max.	25.0-28.0	20.0-22.5	0.75 Max.	0.75 Max.	-	550	30
SUPER TIG 318	ER 318	0.08-0.15	1.0-2.5	0.30-0.65	0.03 Max.	0.03 Max.	18.0-20.0	11.0-14.0	2.0-3.0	0.75 Max.	Cb=8xC min -1.0max	550	25
SUPER TIG 347	ER 347	0.08 Max.	1.0-2.5	0.30-0.65	0.03 Max.	0.03 Max.	19.0-21.5	9.0-11.0	0.75 Max.	0.75 Max.	Cb=8xC min -1.0max	520	30
SUPER TIG 410	ER 410	0.12 Max.	0.60 Max.	0.50 Max.	0.03 Max.	0.03 Max.	11.5-13.5	0.60 Max.	0.75 Max.	0.75 Max.	-	450	20
SUPER TIG 430	ER 430	0.10 Max.	0.60 Max.	0.50 Max.	0.03 Max.	0.03 Max.	15.5-17.0	0.60 Max.	0.75 Max.	0.75 Max.	-	450	20

APPLICATIONS

- Cr Ni alloyed welding wire for Stainless Steel application of all general usage. The deposited metal is sound and resistant to scaling. Recommended for welding AISI:304, 308 and Stainless Steel of similar composition.
- Offer improved arc stability and bead appearance with excellent resistance to inter-granular corrosion. Recommended for welding of AISI 304, 304L, 308, 308L and equivalent Stainless Steel grades.
- Highly alloyed welding wire, depositing a weld metal with excellent crack, heat and corrosion resistibility. Recommended for welding similar (AISI309) as well as dissimilar metal such as Mild Steel to Stainless Steel, Welding clad side of type 304 Clad Steel, for applying SS linings to Carbon Steels.
- Highly alloyed Welding Wire with low Carbon content, this increases the resistance to intergranular corrosion without use of any stabilizing element. Suitable for welding of AISI 309, 309L. MS to SS, and equivalent grades of stainless steel and dissimilar metals.
- For welding of 316 type and similar alloys. The presence of Molybdenum provides creep resistance at elevated temperature and pitting resistance in halide atmosphere. Suitable for welding of AISI 316 and other similar steels.
- Extra low carbon stainless steel filler wire suitable for welding AISI 316, 316L and equivalent Stainless Steel grades, the low carbon content reduces the possibility of inter granular corrosion. This filler wire is primarily used for welding low carbon molybdenum bearing austenitic alloys.
- Cr-Ni alloyed austenitic filler wire suitable for welding heat and corrosion resistant steels of similar composition, to mild and low alloyed steel. The deposited metal in extremely resistant to corrosion and oxidation at high temperature. Scaling temperature 1200°C. Good impact values down to Minus 196°C.
- Cr-Ni-Mo alloyed cb - stabilized stainless steel welding wire, suitable for welding of similar alloyed stabilized and non stabilized stainless steel. The weld metal produced by this filler wire is resistant to inter crystalline corrosion.
- It is a Cr-Ni alloyed Cb stabilized Welding Wire. The presence of Cb provides resistance to inter granular corrosion. This filler metal is usually used for welding of Cr-Ni stainless Steel base metal of similar composition stabilized with Cb or Ti.
- It is a filler welding wire of 12 Cr alloy type air hardening steel. Preheat and post weld heat treatment is recommended for many applications. Suitable for welding of AISI 410 and similar composition alloys. Also used for deposition of overlays on carbon steels to resist corrosion, erosion or abrasion.
- It is filler welding wire of 16-Cr alloy type steel. The presence of adequate percentage of chromium provides corrosion resistance yet retains sufficient ductility in the heat treated condition. Welding with this grade of filler wires usually requires preheating and post-weld heat treatment to obtain optimum results.