

10 lb. SPOOLS cont.

PRODUCT and DESCRIPTION	SIZE	STOCK NUMBER	PRICE PER LB
	<i>ER316L-Si Stainless Steel</i>	.025	316LS17
.030		316LSE7	\$11.73
.035		316LSF7	\$11.09
.045		316LSH7	\$10.76
1/16"		316LS37	\$10.66
<i>ER317L Stainless Steel</i>	.035	0317LF7	\$12.93
	.045	0317LH7	\$12.58
<i>ER347 Stainless Steel</i>	.030	00347E7	\$12.77
	.035	00347F7	\$11.49
	.045	00347H7	\$10.96
	1/16"	003473 7	\$10.84
<i>ER410 Stainless Steel</i>	.035	00410F7	\$7.64
	.045	00410H7	\$7.21

25 lb. SPOOLS (SOLID WIRE)

<i>ER308 Stainless Steel</i>	.025	0030818	\$12.47
	.030	00308E8	\$8.08
	.035	00308F8	\$7.50
	.045	00308H8	\$7.08
	1/16"	0030838	\$6.59
<i>ER308L Stainless Steel</i>	.025	0308L18	\$12.77
	.030	0308LE8	\$8.27
	.035	0308LF8	\$7.73
	.045	0308LH8	\$7.30
	1/16"	0308L38	\$7.12
<i>ER308L-Si Stainless Steel</i>	.025	308LS18	\$13.77
	.030	308LSE8	\$9.27
	.035	308LSF8	\$8.77
	.045	308LSH8	\$8.30
	1/16"	308LS38	\$8.12
<i>ER309 Stainless Steel</i>	.030	00309E8	\$8.97
	.035	00309F8	\$8.90
	.045	00309H8	\$8.67
	1/16"	0030938	\$8.48
<i>ER309L Stainless Steel</i>	.030	0309LE8	\$9.21
	.035	0309LF8	\$9.07
	.045	0309LH8	\$8.86
	1/16"	0309L38	\$8.78
<i>ER309L-Si Stainless Steel</i>	.030	309LSE8	\$10.21
	.035	309LSF8	\$10.07
	.045	309LSH8	\$9.86
	1/16"	309LS38	\$9.78
<i>ER310 Stainless Steel</i>	.030	00310E8	\$12.51
	.035	00310F8	\$11.48
	.045	00310H8	\$10.83
	1/16"	0031038	\$10.60
<i>ER312 Stainless Steel</i>	.035	00312F8	\$14.36
	.045	00312H8	\$14.03
<i>ER316 Stainless Steel</i>	.025	0031618	\$13.98
	.030	00316E8	\$9.35
	.035	00316F8	\$8.80
	.045	00316H8	\$8.48
	1/16"	0031638	\$8.40
<i>ER316L Stainless Steel</i>	.025	0316L18	\$14.20
	.030	0316LE8	\$9.58
	.035	0316LF8	\$9.00
	.045	0316LH8	\$8.71
	1/16"	0316L38	\$8.71
<i>ER316L-Si Stainless Steel</i>	.025	316LS18	\$15.20
	.030	316LSE8	\$10.58
	.035	316LSF8	\$10.00
	.045	316LSH8	\$9.71
	1/16"	316LS38	\$9.71
<i>ER317L Stainless Steel</i>	.035	0317LF8	\$11.55
	.045	0317LH8	\$11.23
<i>ER347 Stainless Steel</i>	.030	00347E8	\$11.40
	.035	00347F8	\$10.26
	.045	00347H8	\$9.79
	1/16"	0034738	\$9.68
<i>ER410 Stainless Steel</i>	.035	00410F8	\$6.82
	.045	00410H8	\$6.44

25 LB. SPOOLS (STAINLESS STEEL FLUX CORED, W/GAS)

<i>E308LT - 1</i>	.035	308LFCF8	\$22.13
	.045	308LFC8H	\$12.88
	1/16"	308LFC38	\$12.09
<i>E309LT - 1</i>	.035	309LFCF8	\$23.66
	.045	309LFC8H	\$14.02
	1/16"	309LFC38	\$12.97
<i>E316LT - 1</i>	.035	316LFCF8	\$23.86
	.045	316LFC8H	\$14.10
	1/16"	316LFC38	\$13.19

STAINLESS STEEL SPOOLED WIRES



SUGGESTIONS FOR WELDING
STAINLESS STEEL

SS FILLER METAL SELECTOR GUIDE

SOLID S STEEL SPOOLED WIRES (continued)

Stainless Steel Gas Shielded Flux Cored Welding Wire

Now we are proud to offer high performance, high productivity, FLUX CORED STAINLESS STEEL WELDING WIRES.

The classifications produced are E308LT-1, E309LT-1, and E316LT-1, not just in the conventional 1/16" wire size but also in .045" and .035" as well.

CHARACTERISTICS: Flux cored stainless steel wires are precisely formulated for all position welding versatility with exceptional performance at high speed deposition rates.

Economy - 100% CO₂ can be used as the shielding gas, even in the vertical-up and overhead positions.

Arc action is smooth and stable; also, the slag peels easily (less cleanup time). Operator appeal is a plus factor.

CHEMICAL COMPOSITIONS:

Product	C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Fe
E308LT-1	0.04	18.0-21.0	9.0-11.0	0.5	0.5-2.5	1.0	0.04	0.03	0.5	Rem.
E309LT-1	0.04	22.0-25.0	12.0-14.0	0.5	0.5-2.5	1.0	0.04	0.03	0.5	Rem.
E316LT-1	0.04	17.0-20.0	11.0-14.0	2.0-3.0	0.5-2.5	1.0	0.04	0.03	0.5	Rem.

(Single values shown are maximum percentages)

PROPERTIES:

Product	Minimum Tensile Strength		Minimum Elongation in 2" (50 mm) Percent
	psi	MPa	
E308LT-1	75,000	515	35
E309LT-1	75,000	515	30
E316LT-1	70,000	485	30

GENERAL USAGE:

In each of these welding wires, the 0.04% maximum carbon content increases resistance to intergranular corrosion.

E308LT-1 is most frequently used for base metals of similar composition such as AISI Types 301, 302, 304, 305 and 308.

E309LT-1 is used for welding similar alloys in wrought or cast form; occasionally, to weld Type 304 base metals when severe corrosion conditions exist; and, at times, welding dissimilar steels.

E316LT-1 is used for welding similar alloys (containing about 2% molybdenum); also for high temperature service applications (the presence of molybdenum provides increased creep resistance at elevated temperatures).

SHIELDING GASES:

100% CO₂ can be used, even in the vertical-up and overhead positions.

If an argon with 20 to 25 percent CO₂ mixture is selected, the voltage may be somewhat lower than with 100% CO₂.

Generally, a gas flow rate of 40 cfm is suggested as a norm from which adjustments can be made, depending on variables encountered.

WIRE STICK-OUT: (DC+)

5/8" to 3/4" is suggested.

NOW AVAILABLE, STAINLESS STEEL SELF SHIELDING (NO GAS NEEDED) FLUX CORE WIRE (DC+)

ALLOY	DESCRIPTION	PART NUMBER	PRICE
308L	1 lb Spool x .035	308LFCO-035-01	\$25.95 EA
308L	1 lb Spool x .045	308LFCO-045-01	\$19.99 EA
308L	10 lb Spool x .035	308LFCO-035-10	\$245.00 EA
308L	10 lb Spool x .045	308LFCO-045-10	\$185.00 EA
308L	25 lb Spool x .035	308LFCO-035-25	\$525.00 EA
308L	25 lb Spool x .045	308LFCO-045-25	\$397.50 EA
309L	1 lb Spool x .035	309LFCO-035-01	\$26.99 EA
309L	1 lb Spool x .045	309LFCO-045-01	\$20.99 EA
309L	10 lb Spool x .035	309LFCO-035-10	\$255.00 EA
309L	10 lb Spool x .045	309LFCO-045-10	\$195.00 EA
309L	25 lb Spool x .035	309LFCO-035-25	\$550.00 EA
309L	25 lb Spool x .045	309LFCO-045-25	\$423.50 EA
312	1 lb Spool x .035	312FCO-035-01	\$27.99 EA
312	1 lb Spool x .045	312FCO-045-01	\$21.99 EA
312	10 lb Spool x .035	312FCO-035-10	\$255.00 EA
312	10 lb Spool x .045	312FCO-045-10	\$195.00 EA
312	25 lb Spool x .035	312FCO-035-25	\$550.00 EA
312	25 lb Spool x .045	312FCO-045-25	\$423.50 EA
316	1 lb Spool x .035	316FCO-035-01	\$26.99 EA
316	1 lb Spool x .045	316FCO-045-01	\$20.99 EA
316	10 lb Spool x .035	316FCO-035-10	\$255.00 EA
316	10 lb Spool x .045	316FCO-045-10	\$195.00 EA
316	25 lb Spool x .035	316FCO-035-25	\$550.00 EA
316	25 lb Spool x .045	316FCO-045-25	\$423.50 EA