



SOLID STAINLESS STEEL WIRES FOR MIG WELDING

CHEMICAL COMPOSITION

MECHANICAL PROPERTIES
OF ALL-WELD METAL IN
AS-WELDED CONDITION

Brand	AWS	Carbon	Manganese	Silicon	Chromium	Nickel	Molybdenum	Sulphur	Phosphorous	Copper	U.T.S.(min)	%EL(min)
Name	Class	C	Mn	Si	Cr	Ni	Mo	S	P	Cu	Mpa	(4d)
MODI MIG 308	ER 308	0.08 max	1.0-2.5	0.30-0.65	19.5-22.0	9.0-11.0	0.75max	0.030max	0.030max	0.75max	550	35
MODI MIG 308L	ER 308L	0.03 max	1.0-2.5	0.30-0.65	19.5-22.0	9.0-11.0	0.75max	0.030max	0.030max	0.75max	520	35
MODI MIG 309	ER 309	0.12 max	1.0-2.5	0.30-0.65	23.0-25.0	12.0-14.0	0.75max	0.030max	0.030max	0.75max	550	30
MODI MIG 309L	ER 309L	0.03 max	1.0-2.5	0.30-0.65	23.0-25.0	12.0-14.0	0.75max	0.030max	0.030max	0.75max	520	30
MODI MIG 310	ER 310	0.08-0.15	1.0-2.5	0.30-0.65	25.0-28.0	20.0-22.5	0.75max	0.030max	0.030max	0.75max	550	30
MODI MIG 316	ER 316	0.08 max	1.0-2.5	0.30-0.65	18.0-20.0	11.0-14.0	2.0-3.0	0.030max	0.030max	0.75max	520	30
MODI MIG 316L	ER 316L	0.03 max	1.0-2.5	0.30-0.65	18.0-20.0	11.0-14.0	2.0-3.0	0.030max	0.030max	0.75max	490	30
*MODI MIG 347	ER 347	0.08 max	1.0-2.5	0.30-0.65	19.0-21.5	9.0-11.0	0.75max	0.030max	0.030max	0.75max	520	30

*Also contains Columbium between 10xC min. to 1.0 max

PACKING SPECIFICATION

Diameter (mm)	0.8	1.2	1.6
Weight per Spool	15 Kg.	15 Kg.	15 Kg.



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