



## SOLID STAINLESS STEEL WIRES FOR TIG 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 TIG 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 TIG 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 TIG 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 TIG 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 TIG 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 TIG 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 TIG 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 TIG 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)	1.6	2.0	2.5	3.15
Length (mm)	1000	1000	1000	1000
Weight per Carton	5.25 Kg.	5.25 Kg.	5.25 Kg.	5.25 Kg.
Weight per Box	21 Kg.	21 Kg.	21 Kg.	21 Kg.



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