

PRODUCT DESCRIPTION:

Satin Glide™ stainless steel welding wires are designed for joining stainless steels, and stainless steels to carbon or low alloy steels. Satin Glide™ is a solid stainless steel weld wire developed specifically for GMAW applications. Drawing, cleaning, and finishing processes produce a unique surface that will not work against you and creates a lustrous satin finish containing our proprietary lubricant.

Stainless steel GMA welding wire for industrial and light duty applications

NS PREMIUM WELDING WIRE CHARACTERISTICS:

- Satin Glide™ stainless steel wires provide the ultimate in flexibility to support your GMAW operations.
- Cast of 30"(.75m) to 50" (1.2m) and Helix below 1" (25.4mm) improve feedability and provide accurate wire positioning
- NS unique wire cleaning process eliminates surface residuals
- Tight ferrite controls
- Superior corrosion resistance
- Manufactured according to ISO9001:2008 quality standards

CLASSIFICATIONS & APPROVALS:

- AWS A5.9/A5.9M:2012
- ASME SFA 5.9
- ASME Section III Nuclear requirements

WELDING POSITIONS:

All position welding is possible when using the correct shielding gas blends, welding process and parameters.

SATIN GLIDE™	Low Carbon	Low Carbon/ High Silicon	Columbium Stabilized
ARC STARTS	Excellent	Excellent	Excellent
ARC STABILITY	Excellent	Excellent	Excellent
FEEDABILITY	Excellent	Excellent	Excellent
INTER-GRANULAR CARBIDE PRECIPITATION	Reduced	Reduced	
SPATTER	Minimal	Minimal	Minimal
FUSION		Excellent	
PUDDLING		More Fluid	
DE-OXIDIZERS		Increased	
WELD APPEARANCE	Excellent	Excellent	Excellent
HIGH TEMPERATURE STRENGTH			Excellent

TYPICAL APPLICATION SHIELDING GAS BLENDS:

Short Circuit Transfer

- 90% Helium / 7-1/2% Argon / 2-1/2% CO₂
- Flow Rate: 35-50 CFH

Spray Transfer

- Argon / Oxygen
- Flow Rate: 35-50 CFH

SATIN GLIDE™ APPLICATIONS:

- Well suited for all metal transfer modes of GMAW
- Robotic, mechanized or semi-automatic welding
- Used for single and multi-pass weldments
- Dissimilar base metal welding – See National Standard Chart for Dissimilar Base Metal Welding

WIRE DIAMETERS (in):

.030	.035	.040	.045	.052	.062	.078	.094	.125
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Note: Contact NS Customer Service for wire diameter availability of each alloy.

SATIN GLIDE™
STAINLESS



TYPICAL WIRE CHEMISTRY:

TYPE	ASME SFA 5.9	AWS A5.9	Other Specifications	Carbon	Cr	Ni	Mn	Si	Other
308L	Yes	Yes	Upon Request	.03 Max	20.00/22.00	9.50/11.00	1.60/2.00	.40/.65	
308LHS	Yes	Yes		.03 Max	20.00/22.00	9.50/11.00	1.60/2.00	.70/1.00	
309L	Yes	Yes		.03 Max	23.00/25.00	12.00/14.00	1.60/2.50	.45/.65	
309LHS	Yes	Yes		.07 Max	23.00/25.00	12.00/14.00	1.60/2.50	.70/1.00	
316L	Yes	Yes		.03 Max	18.00/20.00	12.00/14.00	1.60/2.50	.45/.75	Mo 2.00/2.50
316LHS	Yes	Yes		.03 Max	18.00/20.00	12.00/14.00	1.60/2.25	.70/1.00	Mo 2.00/2.50
409CB		Yes		.05 Max	11.00/12.00	.50 Max	.45/.75	.45/.75	Cb 10xC Min/.60 Max
430L	Yes	Yes		.03 Max	16.00/17.00	.50 Max	.25/.60	.25/.50	
430LCB	Yes	Yes		.03 Max	16.50/19.50	.20/.60	.35/.60	.30/.60	Cb .30/.70 & Mo .20/50

L = Low Carbon LHS = Low Carbon, High Silicon CB = Columbium

STAINLESS STEEL FILLER METALS FOR WELDING DISSIMILAR METALS:

BASE ALLOY	201, 202, 301, 302, 302B, 303, 304, 305, 308	304L	309, 309S	310, 310S, 314	316	316L	317	317L	321, 347, 348	330	403, 405, 410, 414, 416, 420	430, 430F, 431, 440A, 440B, 440C	448	501, 502	505	CARBON STEEL	CR-MO STEEL
201, 202, 301, 302, 302B, 303, 304, 305, 308	308	308	308	308	308	308	308	308	308	309	309	309	310	309	309	309	309
304L		308L	308	308	308	308	308	308	309	309	309	309	310	309	309	309	309
309, 309S			309	309	309	309	309	309	309	309	309	309	310	309	309	309	309
310, 310S, 314				310	316	316	317	317	309	309	309	309	310	310	310	310	309
316					316	316	316	316	308	309 Mo	309	309	310	309	309	309	309
316L						316L	316	316L	308	309 Mo	309	309	310	309	309	309	309
317							317	317	308	309 Mo	309	309	310	309	309	309	309
317L								317L	308L	309 Mo	309	309	310	309	309	309	309
321, 347, 348									347	309	309	309	310	309	309	309	309
330										330	309	309	310	309	309	309	309
403, 405, 410, 414, 416, 420											410	430	410	502	505	410	410
430, 430F, 431, 440A, 440B, 440C												430	430	502	505	430	430
448													448	502	502	430	430
501, 502														502	502	502	502
505															505	505	505

DISCLAIMER:

The information contained or otherwise referenced herein is presented only in "typical" without guarantee or warranty, and National Standard expressly disclaims any liability incurred from any reliance thereon. Typical data are obtained when welded and tested in accordance with AWS specifications. Specification, other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by National Standard LLC.



SATIN GLIDE™ WELDING PARAMETERS AND PACKAGE OPTIONS



APPROXIMATE WELDING PARAMETERS:

WIRE DIAMETER	POLARITY	TRANSFER MODE	SHIELDING GAS	WIRE FEED SPEED (Min.)	ARC VOLTAGE	CURRENT/AMPS
				inches (mm)		
0.035 (.9mm)	DCEP	Short Circuit	90% Helium/7.5% Argon/Bal CO ₂	120-425 (3.0-10.8)	19-23	55-170
	DCEP	Axial Spray		400-475 (10.2-12.1)	22-23	180-210
0.045 (1.1mm)	DCEP	Short Circuit	98% Argon/2% O ₂	100-275 (2.5-7.0)	19-23	10-185
	DCEP	Axial Spray		240-360 (6.1-9.1)	23-25	195-260

PACKAGES
33-lb. Fiber Spool - Random Wound
45-lb. Fiber Spool - Random Wound
60-lb. Fiber Spool - Random Wound
250-lb. Smart Pak - 100% Recyclable
300-lb. Tru-Trac®
500-lb. Drum Pack
500-lb. Smart Pak - 100% Recyclable
900-lb. Drum Pack
900-lb. Smart Pak - 100% Recyclable
425-lb. Trigger Trac®
1,000-lb. Tru-Trac®
1,000-lb. Wood Reel

Note: See "Premium Packaging Options" for full description of packages. For additional packages, please contact NS Customer Service at 1-800-777-1618.

Exclusive to NS customers.

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For Material Safety Data Sheets (MSDS) and Certificates of Compliance, visit our website at www.nationalstandard.com

