

Satin Glide[®] STAINLESS WELDING WIRES

TYPICAL WIRE CHEMISTRY PERCENTAGES (as required per AWS)

| TYPE | ASME SFA 5.9 | AWS A5.9/ AWS A5.9M | Carbon | Cr | Ni | Mn | Si | Other |
|--------|--------------|------------------------|---------|-------------|-------------|-----------|----------|----------------------------------|
| 308L | Yes | Yes | .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 | Yes | .05 Max | 11.00/12.00 | .50 Max | .45/.75 | .45/.75 | Cb 10xC Min/.60 |
| 430L | Yes | Yes | .03 Max | 16.00/17.00 | .50 Max | .25/.60 | .25/.50 | |
| 430LCB | | | .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

APPROXIMATE WELDING PARAMETERS

| DIA. | POLARITY | TRANSFER MODE | SHIELDING GAS | WIRE FEED SPEED in/min | VOLTAGE | AMPERAGE |
|-------|----------|---------------|---|------------------------|---------|----------|
| 0.035 | DCEP | Short Circuit | 90% Helium/ 7.5% Argon/ Bal CO ₂ | 120-425 | 19-23 | 55-170 |
| 0.035 | | Axial Spray | 90% Helium/ 7.5% Argon/ Bal CO ₂ | 400-475 | 22-23 | 180-210 |
| 0.045 | | Short Circuit | 98% Argon/ 2% O ₂ | 100-275 | 19-23 | 10-185 |
| 0.045 | | Axial Spray | 98% Argon/ 2% O ₂ | 240-360 | 23-25 | 195-260 |