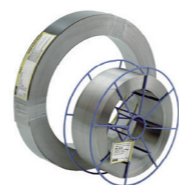


Welding Consumables Selection Chart



Introduction

Welding consumables are specially formulated to ensure corrosion performance and are produced to conform to very tight specifications. The correct choice of consumable for a specific application is extremely important, and nowhere is it more important, for example, than in the construction of pressure vessels.

Vulcan Stainless can supply a welding consumable to meet your needs, one that is precisely adapted to the parent metal and that also has optimal welding characteristics. The following chart is provided as a guide to the correct selection of consumables. For any application out of the ordinary, we can provide the technical expertise to ensure the best result.

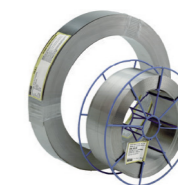
	Carbon Steel	Chrome Moly	ASTM 301/302 304/304L	ASTM 316/316L 316Ti	ASTM 321 347	ASTM 310 310S	253MA (309 HT)*	2RK65
Carbon Steel	E4113							
Chrome Moly	E4818	E8018						
ASTM 301/302	309L	309L	308LSi					
ASTM 304/304L	309LSi	309LSi	308LSi					
ASTM 316/316L	309LSi	309LSi	316LSi	316LSi				
ASTM 316Ti	SAF 2205	SAF 2205	309LSi	318				
ASTM 321/347	309LSi	309LSi	308 Lsi	316LSi	347			
	312	312	309LSi	307Mn	347			
ASTM 310/310S	307Mn	307Mn	307Mn	316LSi	347	310		
	310	312	310	310	310LSi			
253 MA (309 HT)*	309LSi	309LSi	253MA	253MA	253MA	253MA	253MA	
	309LSi	309LSi	347	309LSi	347	310	309LSi	
2RK65	2RK65	2RK65	2RK65	2RK65	2RK65	2RK65	2RK65	2RK65
	San 28	San 28	316LSi	2RK65	2RK65	San 72	San 72	San 72
LDX 2101	23.7.L	23.7.L	23.7.L	23.7.L	23.7.L	23.7.L	23.7.L	23.7.L
SAF 2304	SAF 2205	SAF 2205	SAF 2205	SAF 2205	SAF 2205	SAF 2205	SAF 2205	SAF 2205
SAF 2205	309LSi	309LSi	309LSi	309LSi	309LSi	309LSi	309LSi	SAF 2205
Sanicro 28	San 72	San 72	San 72	San 72	San 72	San 72	San 72	San 28
Sanicro 60	San 60	San 60	San 60	San 60	San 60	San 60	San 60	San 60
Ni-Cr-Fe Alloys	San 72	San 72	San 72	San 72	San 72	San 72	San 72	San 72
ASTM 444	309LSi	309LSi	309LSi	309LSi	309LSi	309LSi	309LSi	2RK65
	316LSi	316LSi	316LSi	316LSi	347	347	San 28	309LSi
5CR12	309LSi/307Mn	309LSi/307Mn	307Mn	316LSi	309LSi	309LSi	309LSi	309LSi
				347	347	347	San 28	2RK65
9% Nickel	San 72	San 72	San 72	San 72	San 72	San 72	San 72	San 72

* Not standard designation – for information only.

Warning!

All the facts concerning your intended application must be considered before careful selection is made. This selection chart is to be used as a guide only. Contact a Vulcan Stainless Welding Specialist for assistance if you require any help in selection.

Welding Consumables Selection Chart (continued)



	LDX 2101	SAF 2304 SAF 2205	Sanicro 28	Sanicro 60	Ni-Cr-Fe Alloys	ASTM 444	5CR12	9% Nickel
Carbon Steel								
Chrome Moly								
ASTM 301/302								
ASTM 304/304L								
ASTM 316/316L								
ASTM 316Ti								
ASTM 321/347								
ASTM 310/310S								
253 MA								
2RK65								
LDX 2101	23.7.L	23.7.L						
SAF 2304		SAF 2205						
SAF 2205								
Sanicro 28		San 28	San 28					
Sanicro 60	San 60	San 60	San 60	San 60	San 60			
Ni-Cr-Fe Alloys		San 72	San 72		San 72			
			San 28					
ASTM 444		309LSi	San 28		San 72	309LSi		
		SAF 2205				316LSi		
5CR12		309LSi	San 28		San 72	309LSi	309LSi/307	
			San 72			307		
9% Nickel		San 72	San 72		San 72	San 72	San 72	San 72