

# GEN<sup>4</sup> STAINLESS STEEL WELDING WIRE

CWI Generation4™ Stainless Welding consumables offer a variety of alloys with particular attributes to meet your product or application requirements. Whether you need corrosion resistance, strength, or ductility, we have a product that will exceed your expectations. And when the proper welding process is used, there is little that our collection of austenitic, martensitic, ferritic, duplex, and precipitation-hardening alloys can't accomplish. Below is a chart of standard Stainless Steel Welding Wire alloys that we offer from stock:

Typical Chemical Composition of Gen <sup>4</sup> of Stainless Steel Wires														
Product	Specifications - AWS A5.9	C	Mn	Si	Fe	Cr	Mo	Ni	Nb+Ta	N	S	P	Cu	FN
GEN 307*		0.07	6.60	0.90	Bal	18.70		8.90			0.007	0.015		5
GEN 308/308H	ER308H	0.05	1.65	0.46	Bal	20.45		9.85			0.005	0.016		8
GEN 308/308L	ER308L	0.019	1.72	0.46	Bal	20.80		10.10			0.003	0.013		8
GEN 308Si/309Lsi	ER308Lsi	0.016	1.65	0.85	Bal	20.65		10.00			0.008	0.016		8
GEN 309/309L	ER309L	0.021	1.75	0.51	Bal	23.40		12.70			0.006	0.014		12
GEN 309Si/309Lsi	ER309Lsi	0.019	1.85	0.84	Bal	23.50		12.95			0.004	0.012		10
GEN 310	ER310	0.11	1.90	0.40	Bal	38.10		20.95			0.003	0.012		0
GEN 312	ER312	0.11	1.64	0.44	Bal	29.60		8.90			0.012	0.017		30 min
GEN 316/316L	ER316L	0.016	1.87	0.48	Bal	19.32	2.25	13.20			0.010	0.019		6
GEN 316Si/316Lsi	ER316Lsi	0.022	1.80	0.85	Bal	19.25	2.45	12.60			0.004	0.013		8
GEN 317L	ER317L	0.017	1.66	0.44	Bal	19.40	3.25	13.85			0.006	0.012		6
GEN 320LR	ER320LR	0.025	1.60	0.05	Bal	19.60	2.50	34.10	0.25		0.001	0.007	3.40	0
GEN 330	ER330	0.23	1.95	0.42	Bal	15.95		35.20			0.005	0.014		0
GEN 347	ER347	0.04	1.65	0.52	Bal	19.90		9.75	0.72		0.005	0.014		10
GEN 385	ER385	0.019	2.05	0.35	Bal	20.50	4.60	25.10			0.015	0.014	1.60	0
GEN 409Nb	ER410NiMo	0.05	0.62	0.48	Bal	11.50			0.35		0.016	0.018		
GEN 410	ER410	0.11	0.45	0.39	Bal	12.50					0.010	0.014		
GEN 410NiMo	ER410NiMo	0.02	0.45	0.40	Bal	11.80	0.55	4.50			0.009	0.012		
GEN 420	ER420	0.29	0.45	0.35	Bal	13.20					0.008	0.014		
GEN 430	ER430	0.07	0.44	0.36	Bal	16.50					0.010	0.014		
GEN 430LCb	ER430LCb	0.01	0.51	0.40	Bal	18.20			0.40		0.008	0.020		
GEN 630	ER630	0.03	0.54	0.43	Bal	16.49	0.20	4.78	0.22		0.021	0.017	3.60	
GEN 2209	ER2209	0.016	1.40	0.45	Bal	22.40	3.20	8.50		0.18	0.017	0.014		40 min
GEN 2594	ER2594	0.07	1.00	1.00	Bal	25.50	3.95	9.25		0.25	0.010	0.025	0.50	40 min

\*EN ISO 14343

