

第 11 表 AWS ステンレス鋼被覆アーク溶接棒 (AWS A 5.4:2006 抜粋)

| AWS Classification | C         | Cr        | Ni        | Mo      | Cb+Ta     | Mn        | Si   | P    | S    | N         | Cu   | Other       | 級                                      | 柄 |
|--------------------|-----------|-----------|-----------|---------|-----------|-----------|------|------|------|-----------|------|-------------|--|---|
| E209 e             | 0.06      | 20.5~24.0 | 9.5~12.0  | 1.5~3.0 | —         | 4.0~7.0   | 1.00 | 0.04 | 0.03 | 0.10~0.30 | 0.75 | V:0.10~0.30 |  |   |
| E219               | 0.06      | 19.0~21.5 | 5.5~7.0   | 0.75    | —         | 8.0~10.0  | 1.00 | 0.04 | 0.03 | 0.10~0.30 | 0.75 |             |  |   |
| E240               | 0.06      | 17.0~19.0 | 4.0~6.0   | 0.75    | —         | 10.5~13.5 | 1.00 | 0.04 | 0.03 | 0.10~0.20 | 0.75 |             |  |   |
| E307               | 0.04~0.14 | 18.0~21.5 | 9.0~10.7  | 0.5~1.5 | —         | 3.3~4.75  | 1.00 | 0.04 | 0.03 | —         | 0.75 |             |  |   |
| E308               | 0.08      | 18.0~21.0 | 9.0~11.0  | 0.75    | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 308                                |   |
| E308H              | 0.04~0.08 | 18.0~21.0 | 9.0~11.0  | 0.75    | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 308HTS                             |   |
| E308L              | 0.04      | 18.0~21.0 | 9.0~11.0  | 0.75    | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 308L, 308ELC, 308ULC, 308LA, 308Lk |   |
| E308Mo             | 0.08      | 18.0~21.0 | 9.0~12.0  | 2.0~3.0 | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             |  |   |
| E308LMo            | 0.04      | 18.0~21.0 | 9.0~12.0  | 2.0~3.0 | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             |  |   |
| E309               | 0.15      | 22.0~25.0 | 12.0~14.0 | 0.75    | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 309, 309K                          |   |
| E309H              | 0.04~0.15 | 22.0~25.0 | 12.0~14.0 | 0.75    | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             |  |   |
| E309L              | 0.04      | 22.0~25.0 | 12.0~14.0 | 0.75    | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 309L, 309LB                        |   |
| E309Nb             | 0.12      | 22.0~25.0 | 12.0~14.0 | 0.75    | 0.70~1.00 | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 309Nb                              |   |
| E309Mo             | 0.12      | 22.0~25.0 | 12.0~14.0 | 2.0~3.0 | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 309Mo                              |   |
| E309LMo            | 0.04      | 22.0~25.0 | 12.0~14.0 | 2.0~3.0 | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 309MoL                             |   |
| E310               | 0.08~0.20 | 25.0~28.0 | 20.0~22.5 | 0.75    | —         | 1.0~2.5   | 0.75 | 0.03 | 0.03 | —         | 0.75 |             | WEL 310                                |   |
| E310H              | 0.35~0.45 | 25.0~28.0 | 20.0~22.5 | 0.75    | —         | 1.0~2.5   | 0.75 | 0.03 | 0.03 | —         | 0.75 |             |  |   |
| E310Nb             | 0.12      | 25.0~28.0 | 20.0~22.0 | 0.75    | 0.70~1.00 | 1.0~2.5   | 0.75 | 0.03 | 0.03 | —         | 0.75 |             | WEL 310Nb                              |   |
| E310Mo             | 0.12      | 25.0~28.0 | 20.0~22.0 | 2.0~3.0 | —         | 1.0~2.5   | 0.75 | 0.03 | 0.03 | —         | 0.75 |             | WEL 310Mo                              |   |
| E312               | 0.15      | 28.0~32.0 | 8.0~10.5  | 0.75    | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 312                                |   |
| E316               | 0.08      | 17.0~20.0 | 11.0~14.0 | 2.0~3.0 | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 316                                |   |
| E316H              | 0.04~0.08 | 17.0~20.0 | 11.0~14.0 | 2.0~3.0 | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             |  |   |
| E316L              | 0.04      | 17.0~20.0 | 11.0~14.0 | 2.0~3.0 | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             | WEL 316L, 316ELC, 316ULC, 316LA, 316Lk |   |
| E316LMn            | 0.04      | 18.0~21.0 | 15.0~18.0 | 2.5~3.5 | —         | 5.0~8.0   | 0.90 | 0.04 | 0.03 | 0.10~0.25 | 0.75 |             |  |   |
| E317               | 0.08      | 18.0~21.0 | 12.0~14.0 | 3.0~4.0 | —         | 0.5~2.5   | 1.00 | 0.04 | 0.03 | —         | 0.75 |             |  |   |

|            |           |            |           |           |                |           |      |       |       |           |           |  |
|------------|-----------|------------|-----------|-----------|----------------|-----------|------|-------|-------|-----------|-----------|--|
| E317L      | 0.04      | 18.0~21.0  | 12.0~14.0 | 3.0~4.0   | —              | 0.5~2.5   | 1.00 | 0.04  | 0.03  | —         | 0.75      | WEL 317L, 317ELC   |
| E318       | 0.08      | 17.0~20.0  | 11.0~14.0 | 2.0~3.0   | 6×Cmin~1.00max | 0.5~2.5   | 1.00 | 0.04  | 0.03  | —         | 0.75      | WEL 318  |
| E320       | 0.07      | 19.0~21.0  | 32.0~36.0 | 2.0~3.0   | 8×Cmin~1.00max | 0.5~2.5   | 1.00 | 0.04  | 0.03  | —         | 3.0~4.0   |  |
| E320LR     | 0.03      | 19.0~21.0  | 32.0~36.0 | 2.0~3.0   | 8×Cmin~0.40max | 1.50~2.50 | 0.30 | 0.020 | 0.015 | —         | 3.0~4.0   | WEL 320LR  |
| E330       | 0.18~0.25 | 14.0~17.0  | 33.0~37.0 | 0.75      | —              | 1.0~2.5   | 1.00 | 0.04  | 0.03  | —         | 0.75      | WEL 330  |
| E330H      | 0.35~0.45 | 14.0~17.0  | 33.0~37.0 | 0.75      | —              | 1.0~2.5   | 1.00 | 0.04  | 0.03  | —         | 0.75      |  |
| E347       | 0.08      | 18.0~21.0  | 9.0~11.0  | 0.75      | 8×Cmin~1.00max | 0.5~2.5   | 1.00 | 0.04  | 0.03  | —         | 0.75      | WEL 347, 347LF, 347L, 347H   |
| E349 e.f.g | 0.13      | 18.0~21.0  | 8.0~10.0  | 0.35~0.65 | 0.75~1.2       | 0.5~2.5   | 1.00 | 0.04  | 0.03  | —         | 0.75      | V <sub>0.10</sub> -0.30<br>Ti <sub>0.15</sub> MAX<br>W <sub>1.25</sub> -1.75 |
| E383       | 0.03      | 26.5~28.0  | 30.0~33.0 | 3.2~4.2   | —              | 0.5~2.5   | 0.90 | 0.02  | 0.02  | —         | 0.6~1.5   |  |
| E385       | 0.03      | 19.5~21.5  | 24.0~26.0 | 4.2~5.2   | —              | 1.0~2.5   | 0.90 | 0.03  | 0.02  | —         | 1.2~2.0   |  |
| E409Nb     | 0.12      | 11.0~14.0  | 0.6       | 0.75      | 0.50~1.50      | 1.0       | 1.00 | 0.04  | 0.03  | —         | 0.75      |  |
| E410       | 0.12      | 11.0~13.5  | 0.7       | 0.75      | —              | 1.0       | 0.90 | 0.04  | 0.03  | —         | 0.75      | WEL 410  |
| E410NiMo   | 0.06      | 11.0~12.5  | 4.0~5.0   | 0.40~0.70 | —              | 1.0       | 0.90 | 0.04  | 0.03  | —         | 0.75      | WEL 410NiMo  |
| E430       | 0.10      | 15.0~18.0  | 0.6       | 0.75      | —              | 1.0       | 0.90 | 0.04  | 0.03  | —         | 0.75      | WEL 430  |
| E430Nb     | 0.10      | 15.0~18.0  | 0.6       | 0.75      | 0.50~1.50      | 1.0       | 1.00 | 0.04  | 0.03  | —         | 0.75      |  |
| E630       | 0.05      | 16.0~16.75 | 4.5~5.0   | 0.75      | 0.15~0.30      | 0.25~0.75 | 0.75 | 0.04  | 0.03  | —         | 3.25~4.00 | WEL 630  |
| E16-8-2    | 0.10      | 14.5~16.5  | 7.5~9.5   | 1.0~2.0   | —              | 0.5~2.5   | 0.60 | 0.03  | 0.03  | —         | 0.75      | WEL 16-8-2   |
| E239       | 0.04      | 21.5~23.5  | 8.5~10.5  | 2.5~3.5   | —              | 0.5~2.0   | 1.00 | 0.04  | 0.03  | 0.08~0.20 | 0.75      | WEL 329J3L   |
| E253       | 0.06      | 24.0~27.0  | 6.5~8.5   | 2.9~3.9   | —              | 0.5~1.5   | 1.00 | 0.04  | 0.03  | 0.10~0.25 | 1.5~2.5   |  |
| E293       | 0.04      | 24.0~27.0  | 8.5~10.5  | 2.9~3.9   | —              | 0.5~1.5   | 1.00 | 0.04  | 0.03  | 0.08~0.25 | 1.5~3.0   |  |
| E294       | 0.04      | 24.0~27.0  | 8.0~10.5  | 3.5~4.5   | —              | 0.5~2.0   | 1.00 | 0.04  | 0.03  | 0.20~0.30 | 0.75      | WEL 329J4L   |
| E295       | 0.04      | 24.0~27.0  | 8.0~10.5  | 2.5~4.5   | —              | 2.5       | 1.20 | 0.03  | 0.025 | 0.20~0.30 | 0.4~1.5   | W.04~1.0   |
| E3155      | 0.10      | 20.0~22.5  | 19.0~21.0 | 2.5~3.5   | 0.75~1.25      | 1.0~2.5   | 1.00 | 0.04  | 0.03  | —         | 0.75      | Co:18.5~21.0<br>W:2.0~3.0  |
| E3331      | 0.03      | 31.0~35.0  | 30.0~32.0 | 1.0~2.0   | —              | 2.5~4.0   | 0.90 | 0.02  | 0.01  | 0.3~0.5   | 0.4~0.8   |  |

- a. 分析は表の中で特定の値を示した元素について行う事。しかしながら、もし日常分析中に他の元素の存在が示されたならば、さらに分析を行って鉄を除く他の元素の合計が0.5%を越えないか決める事。
- b. 他に規定しなければ単一の値は最大%を示す。
- e. Vは0.10~0.30%とする事。  
f. Tiは0.15%以下の事。  
g. Wは1.25~1.75%とする事。