

第 12 表 AWS 溶接用ステンレス鋼棒およびワイヤ (AWS A 5.9-2006 抜粋)

AWS Classification	C	Cr	Ni	Mo	Cb+Ta	Mn	Si	P	S	N	Cu	Other	鉄	柄
ER209	0.05	20.5~24.0	9.5~12.0	1.5~3.0	—	4.0~7.0	0.90	0.03	0.03	0.10~0.30	0.75	V:0.10~0.30		
ER218	0.10	16.0~18.0	8.0~9.0	0.75	—	7.0~9.0	3.5~4.5	0.03	0.03	0.08~0.18	0.75			
ER219	0.05	19.0~21.5	5.5~7.0	0.75	—	8.0~10.0	1.00	0.03	0.03	0.10~0.30	0.75			
ER240	0.05	17.0~19.0	4.0~6.0	0.75	—	10.5~13.5	1.00	0.03	0.03	0.10~0.30	0.75			
ER307	0.04~0.14	19.5~22.0	8.0~10.7	0.5~1.5	—	3.3~4.75	0.30~0.65	0.03	0.03	—	0.75			
ER308	0.08	19.5~22.0	9.0~11.0	0.75	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			WEL TIG 308 WEL MIG 308
ER308Si	0.08	19.5~22.0	9.0~11.0	0.75	—	1.0~2.5	0.65~1.00	0.03	0.03	—	0.75			
ER308H	0.04~0.08	19.5~22.0	9.0~11.0	0.75	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			WEL TIG 308HTS WEL MIG 308HTS
ER308L	0.03	19.5~22.0	9.0~11.0	0.75	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			WEL TIG 308L, 308ELC, 308ULC, 308LC WEL MIG 308L, 308ELC, 308ULC, 308LC
ER308LSi	0.03	19.5~22.0	9.0~11.0	0.75	—	1.0~2.5	0.65~1.00	0.03	0.03	—	0.75			WEI MIG 308LSi
ER308Mo	0.08	18.0~21.0	9.0~12.0	2.0~3.0	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			
ER308LMo	0.04	18.0~21.0	9.0~12.0	2.0~3.0	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			
ER309	0.12	23.0~25.0	12.0~14.0	0.75	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			WEL TIG 309 WEL MIG 309
ER309Si	0.12	23.0~25.0	12.0~14.0	0.75	—	1.0~2.5	0.65~1.00	0.03	0.03	—	0.75			
ER309L	0.03	23.0~25.0	12.0~14.0	0.75	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			WEL TIG 309L WEL MIG 309L
ER309LSi	0.03	23.0~25.0	12.0~14.0	0.75	—	1.0~2.5	0.65~1.00	0.03	0.03	—	0.75			WEL MIG 309LSi
ER309Mo	0.12	23.0~25.0	12.0~14.0	2.0~3.0	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			
ER309LMo	0.03	23.0~25.0	12.0~14.0	2.0~3.0	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			
ER310	0.08~0.15	25.0~28.0	20.0~22.5	0.75	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			WEL TIG 310 WEL MIG 310
ER312	0.15	28.0~32.0	8.0~10.5	0.75	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			WEL TIG 312 WEL MIG 312
ER316	0.08	18.0~20.0	11.0~14.0	2.0~3.0	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			WEL TIG 316 WEL MIG 316
ER316Si	0.08	18.0~20.0	11.0~14.0	2.0~3.0	—	1.0~2.5	0.65~1.00	0.03	0.03	—	0.75			
ER316H	0.04~0.08	18.0~20.0	11.0~14.0	2.0~3.0	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			
ER316L	0.03	18.0~20.0	11.0~14.0	2.0~3.0	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			WEL TIG 316L, 316ELC, 316ULC, 316LC WEL MIG 316L, 316ELC, 316ULC, 316LC
ER316LSi	0.03	18.0~20.0	11.0~14.0	2.0~3.0	—	1.0~2.5	0.65~1.00	0.03	0.03	—	0.75			WEL MIG 316LSi
ER316LMn	0.03	19.0~22.0	15.0~18.0	2.5~3.5	—	5.0~9.0	0.30~0.65	0.03	0.03	0.10~0.20	0.75			
ER317	0.08	18.5~20.5	13.0~15.0	3.0~4.0	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75			

ER317L	0.03	18.5~20.5	13.0~15.0	3.0~4.0	—	1.0~2.5	0.20~0.65	0.03	0.03	—	0.75	WEL TIG 317L WEL MIG 317L
ER318	0.08	18.0~20.0	11.0~14.0	2.0~3.0	8×Cmin~1.0max	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75	WEL TIG 318 WEL MIG 318
ER320	0.07	19.0~21.0	32.0~36.0	2.0~3.0	8×Cmin~1.0max	2.5	0.60	0.03	0.03	—	3.0~4.0	
ER320LR	0.025	19.0~21.0	32.0~36.0	2.0~3.0	8×Cmin~0.40max	1.5~2.0	0.15	0.015	0.020	—	3.0~4.0	WEL TIG 320LR
ER321	0.08	18.5~20.5	9.0~10.5	0.75	—	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75	Ti9×C~1.0max
ER320	0.18~0.25	15.0~17.0	34.0~37.0	0.75	—	1.0~2.5	0.20~0.65	0.03	0.03	—	0.75	WEL TIG 320 WEL MIG 320
ER347	0.08	19.0~21.5	9.0~11.0	0.75	10×Cmin~1.0max	1.0~2.5	0.30~0.65	0.03	0.03	—	0.75	WEL TIG 347H WEL MIG 347H
ER347Si	0.08	19.0~21.5	9.0~11.0	0.75	10×Cmin~1.0max	1.0~2.5	0.65~1.00	0.03	0.03	—	0.75	WEL MIG 347Si
ER383	0.025	26.5~28.5	30.0~33.0	3.2~4.2	—	1.0~2.5	0.50	0.02	0.03	—	0.70~1.50	
ER385	0.025	19.5~21.5	24.0~26.0	4.2~5.2	—	1.0~2.5	0.50	0.02	0.03	—	1.2~2.0	
ER409	0.08	10.5~13.5	0.6	0.50	—	0.8	0.8	0.03	0.03	—	0.75	Ti10×Cmin~1.5max
ER409Nb	0.08	10.5~13.5	0.6	0.50	10×min~0.75max	0.8	1.0	0.04	0.03	—	0.75	
ER410	0.12	11.5~13.5	0.6	0.75	—	0.6	0.50	0.03	0.03	—	0.75	WEL TIG 410 WEL MIG 410
ER410NiMo	0.06	11.0~12.5	4.0~5.0	0.4~0.7	—	0.6	0.50	0.03	0.03	—	0.75	WEL TIG 410NiMo WEL MIG 410NiMo
ER420	0.25~0.40	12.0~14.0	0.6	0.75	—	0.6	0.50	0.03	0.03	—	0.75	
ER430	0.10	15.5~17.0	0.6	0.75	—	0.6	0.50	0.03	0.03	—	0.75	WEL TIG 430 WEL MIG 430
ER439	0.04	17.0~19.0	0.6	0.5	—	0.8	0.8	0.03	0.03	—	0.75	Ti10×Cmin~1.1max
ER446LMo	0.015	25.0~27.5		0.75~1.50	—	0.4	0.4	0.02	0.015	—		
ER630	0.05	16.0~167.5	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 TIG 630 WEL MIG 430
ER19-10H	0.04~0.08	18.5~20.0	9.0~11.0	0.25	0.05	1.0~2.0	0.30~0.65	0.03	0.03	—	0.75	
ER16-8-2	0.10	14.5~16.5	7.5~9.5	1.0~2.0	—	1.0~2.5	0.20~0.65	0.03	0.03	—	0.75	WEL TIG 16-8-2 WEL MIG 16-8-2
ER2209	0.03	21.5~23.5	7.5~9.5	2.5~3.5	—	0.5~2.0	0.90	0.03	0.03	0.08~0.20	0.75	WEL TIG 329J3L
ER2553	0.04	24.0~27.0	4.5~6.5	2.9~3.9	—	1.5	1.0	0.04	0.03	0.10~0.25	1.5~2.5	
ER2594	0.03	24.0~27.0	8.0~10.5	2.5~4.5	—	2.5	1.0	0.03	0.02	0.20~0.30	1.5	WEL TIG 329J4L
ER33-31	0.015	31.0~35.0	30.0~33.0	0.5~2.0	—	2.00	0.50	0.02	0.01	0.35~0.60	0.3~1.2	
ER3556	0.05~0.15	21.0~23.0	19.0~22.5	2.5~4.0	0.30	0.50~2.00	0.20~0.80	0.04	0.015	0.10~0.30	—	Co:160~210 W:2.0~3.5 Ta:0.30~1.25 Al:0.001~0.300 Zr:0.001~0.100 La:0.005~0.100 B:0.02

他に Auto TIG ワイヤもご用意です。