

## Submerged Arc Welding Materials for Stainless Steel

Brand Name	Specification		Application and Characteristics
	JIS	AWS	
Y-308 × BF-300M	☆Z 3324 YWS308	☆A5.9 ER308	Welding of SUS304
	Welding Position	<span style="border: 1px solid black;">AWS/ASME</span> F/1G	HF/2F
Y-308L × BF-300M	☆Z 3324 YWS308L	☆A5.9 ER308L	Welding of SUS304L
	Welding Position	<span style="border: 1px solid black;">AWS/ASME</span> F/1G	HF/2F
Y-304N × BF-308N2	—	—	Welding of SUS304N2
	Welding Position	<span style="border: 1px solid black;">AWS/ASME</span> F/1G	HF/2F
Y-309 × BF-300M	☆Z 3324 YWS309	☆A5.9 ER309	25% Cr-12% Ni weld metal shows extremely high crack resistance due to its high ferrite content.
	Welding Position	<span style="border: 1px solid black;">AWS/ASME</span> F/1G	HF/2F
Y-309 × BF-300F	☆Z 3324 YWS309	☆A5.9 ER309	
	Welding Position	<span style="border: 1px solid black;">AWS/ASME</span> F/1G	HF/2F
Y-316 × BF-300M	☆Z 3324 YWS316	☆A5.9 ER316	Welding of SUS316
Y-316 × BF-300F	Welding Position	<span style="border: 1px solid black;">AWS/ASME</span> F/1G	HF/2F
Y-316L × BF-300M	☆Z 3324 YWS316L	☆A5.9 ER316L	Welding of SUS316L
Y-316L × BF-300F	Welding Position	<span style="border: 1px solid black;">AWS/ASME</span> F/1G	HF/2F
Y-347 × BF-300M	☆Z 3324 YWS347	☆A5.9 ER347	Welding of SUS347
	Welding Position	<span style="border: 1px solid black;">AWS/ASME</span> F/1G	HF/2F
Y-170 × BF-300M	—	—	Welding of YUS <sup>®</sup> 170
	Welding Position	<span style="border: 1px solid black;">AWS/ASME</span> F/1G	HF/2F

Note : Figure of illustration relating to the symbol of welding position in the table mentioned above.



Typical chemical compositions of weld metal (%)							Typical mechanical properties of weld metal	
C	Si	Mn	Ni	Cr	Mo	Other	TS, MPa	El, %
0.05	0.48	1.95	9.4	20.4	—	—	570	45
0.03	0.47	1.93	10.8	19.7	—	—	550	41
0.07	0.85	3.20	8.0	22.7	—	Nb: 0.09 N: 0.18	715	37
0.06	0.45	1.64	13.5	24.0	—	—	590	38
0.06	0.49	1.46	9.8	21.7	—	—	640	44
0.05	0.55	1.68	12.6	19.8	2.25	—	600	butt weld
0.03	0.53	1.60	13.3	19.7	2.29	—	570	40
0.05	0.55	1.82	10.1	19.9	—	Nb: 0.65	590	38
0.05	0.99	1.68	12.6	25.4	0.81	N: 0.28	740	51