









Covered Arc Welding Electrodes for Stainless Steel

Brand Name	Specification		Dia. mm	Application and Characteristics
	JIS	AWS		
S-309M•R	Z 3221 ES-309Mo-16	☆A5.4 E309Mo-16	2.6 3.2 4.0 5.0	Welding of dissimilar metals such as 18%Cr-12%Ni-2%Mo stainless steel to mild steel
	Welding Position	 F/1G	HF/2F	H/2G OH/4G VU/3G
S-310•R	Z 3221 ES310-16	☆A5.4 E310-16	2.0 2.6 3.2 4.0 5.0	Welding of SUS310
	Welding Position	 F/1G	HF/2F	H/2G OH/4G VU/3G
S-316•R	Z 3221 ES316-16	☆A5.4 E316-16	2.0 2.6 3.2 4.0 5.0	Welding of SUS316
	Welding Position	 F/1G	HF/2F	H/2G OH/4G VU/3G
S-316LN•R	—	—	2.6 3.2 4.0 5.0	Welding of SUS316LN
	Welding Position	 F/1G	HF/2F	H/2G OH/4G VU/3G
S-316CL•R	Z 3221 ES316LCu-16	—	2.6 3.2 4.0 5.0	Welding of SUS316J1L
	Welding Position	 F/1G	HF/2F	H/2G OH/4G VU/3G
S-317L•R	Z 3221 ES317L-16	☆A5.4 E317L-16	2.6 3.2 4.0 5.0	Welding of SUS317L
	Welding Position	 F/1G	HF/2F	H/2G OH/4G VU/3G
S-347•R	Z 3221 ES347-16	☆A5.4 E347-16	2.6 3.2 4.0 5.0	Welding of SUS321 or 347
	Welding Position	 F/1G	HF/2F	H/2G OH/4G VU/3G
S-347L•R	Z 3221 ES347L-16	☆A5.4 E347-16	2.6 3.2 4.0 5.0	Welding of low-C type for SUS347
	Welding Position	 F/1G	HF/2F	H/2G OH/4G VU/3G

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, %
0.08	0.41	1.68	13.2	24.1	2.51	—	650	34
0.07	0.41	1.93	21.3	26.0	—	—	570	36
0.05	0.33	1.48	12.9	18.3	2.35	—	590	37
0.023	0.38	1.54	11.9	19.2	2.3	N: 0.15	610	39
0.03	0.33	1.61	13.7	18.5	2.40	Cu: 1.60	570	36
0.034	0.46	1.77	13.2	19.7	3.26	—	610	35
0.05	0.37	1.58	9.7	20.4	—	Nb: 0.68	670	38
0.026	0.78	1.61	10.2	19.3	—	Nb: 0.40	590	39