

STAINLESS STEEL CONSUMABLES CLASSIFICATION FOR ALL PROCESSES

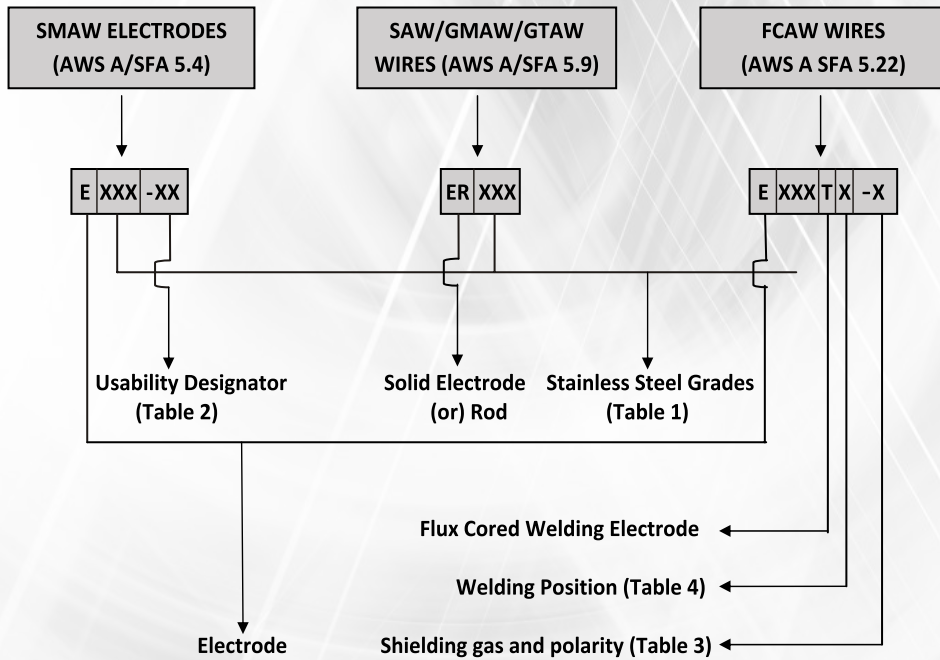


Table 1: Stainless Steel Grades

Code Digit	Stainless Steel Type	Alloy Type
200 series	Austenitic	Cr-Ni-Mn
300 series	Austenitic	Cr-Ni-Mo
400 series	Ferritic & Martensitic	Cr alloy
600 series	Martensitic precipitation hardening	Cr-Ni-Cu
2000 series	Duplex / Super Duplex	Cr-Ni-Mo-N

Table 2: Usability Designator

Code Digit	Current	Welding Position
15	DCEP	F,H,V-up, OH
16	DCEP & AC	F,H,V-up, OH
17	DCEP & AC	F,H,V-up, OH
26 (Synthetic)	DCEP & AC	F,H-fillet

Table 3: Shielding Gas & Polarity

Code Digit	Gas type	Polarity	Welding process
1	CO ₂	DCEP	FCAW
3	Self-shielded	DCEP	FCAW
4	75-80% Ar / CO ₂	DCEP	FCAW
5	100% Ar	DCEN	GTAW

Table 4: Welding position

Code Digit	Welding Position
0	F, H
1	F, H, V-up, V-down, OH



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