



Stainless Steel

Typical filler metals for welding Stainless Steel

Base materials		Service condition	HILCO WELDING CONSUMABLES FOR WELDING STAINLESS STEEL	
Wrought	Cast		Stick electrodes	Other filler metals
201 202 301 302 304 305 308	CF-8 CF-20	As welded or annealed	Hilchrome 308R	Hilchrome G308L Si Hilchrome W308L
302B	-	As welded	Hilchrome 309R Hilchrome 310R	Hilchrome G309L Si Hilchrome W309L
303 303Se	-	As welded or annealed	Hilchrome 312R Hilchrome 309R	Hilchrome G309L Si Hilchrome W309L
304L	CF-3	As welded	Hilchrome 308R Hilchrome 347R	Hilchrome G308L Si Hilchrome W308L
308L	-	As welded	Hilchrome 308R	Hilchrome G308L Si Hilchrome W308L
309	CH-20	As welded	Hilchrome 309R	Hilchrome G309L Si Hilchrome W309L
310	CK-20	As welded	Hilchrome 310R	-
310S	-	As welded	Hilchrome 310R	-
316	CF-8M CF-12M	As welded or annealed	Hilchrome 316R	Hilchrome G316L Si Hilchrome W316L
316L	CF-3M	As welded or stress relieved	Hilchrome 316R	Hilchrome G316L Si Hilchrome W316L
321 321H	-	As welded	Hilchrome 347R	-
347 347H 348 348H	-	As welded	Hilchrome 347R	-
410	-	As welded	Hilchrome 308R, 309R, 310R	308, 309 Grades
405	-	As welded	Hilchrome 308R, 309R, 310R	308, 309 Grades
420	-	As welded	Hilchrome 308R, 309R, 310R	308, 309 Grades
430	-	As welded	Hilchrome 308R, 309R, 310R	308, 309 Grades
431	-	As welded	Hilchrome 308R, 309R, 310R	308, 309 Grades
442	-	As welded	Hilchrome 308R, 309R, 310R	308, 309 Grades

For other base materials we recommend that you contact us for more detailed information.