



### Filler Metals for Welding Ferritic Stainless Steels

| BASE STAINLESS STEEL |       | RECOMMENDED FILLER METAL |                        |                |
|----------------------|-------|--------------------------|------------------------|----------------|
| Wrought              | Cast  | Coated Electrode         | Solid, Metal Core Wire | Flux Core Wire |
| 405                  | CB-30 | E410NiMo, E430           | ER410NiMo, ER430       | E410NiMoTX-X   |
| 409                  |       |                          | ER409, AM363, EC409    | E409TX-X       |
| 429                  |       |                          | ER409Cb                |                |
| 430                  |       | E430                     | ER430                  | E430TX-X       |
| 430F                 |       | E430                     | ER430                  | E430TX-X       |
| 430FSe               |       | E430                     | ER430                  | E430TX-X       |
| 434                  |       |                          | ER434                  |                |
| 442                  | CC-50 | E442, E446               | ER442                  |                |
| 444                  |       | E316L                    | ER316L                 |                |
| 446                  |       | E446                     | ER446                  |                |
| 26-1                 |       |                          | ER26-1                 |                |

From AWS Filler Metal Specifications: A5.4, A5.9, A5.22

### Filler Metals for Welding Martensitic and Duplex Stainless Steels

| BASE STAINLESS STEEL |        | RECOMMENDED FILLER METAL |                        |                     |
|----------------------|--------|--------------------------|------------------------|---------------------|
| Wrought              | Cast   | Coated Electrode         | Solid, Metal Core Wire | Flux Core Wire      |
| 403                  | CA-15  | E410                     | ER410                  | E410TX-X            |
| 410                  |        | E410, E410NiMo           | ER410, ER410NiMo       | E410T, E410NiMoTX-X |
| 410S                 |        | E410NiMo                 | ER410NiMo              | E410NiMoTX-X        |
| 414                  |        | E410                     | ER410                  | E410TX-X            |
| 416                  |        | E410                     | ER312, ER410           |                     |
| 416Se                | CA-90  |                          | ER312                  |                     |
| 416PlusX             |        |                          | ER312                  |                     |
| 420                  |        | E410, E430               | ER420, ER410           | E410TX-X            |
| 420F                 |        |                          | ER312                  |                     |
| 431                  |        | E410, E430               | ER410                  | E410TX-X            |
| 440A                 | CB-30  | a                        |                        |                     |
| 440B                 |        | a                        |                        |                     |
| 440C                 |        | a                        |                        |                     |
|                      | CA-6NM | E410NiMo                 | ER410NiMo              | E410NiMoTX-X        |
|                      | CA-15  | E430                     | ER430                  | E430TX-X            |
| 2205                 |        | E2209                    | ER2209                 |                     |
| 2304                 |        | E2209                    | ER2209                 |                     |
| 255                  |        | E2553                    | ER2553                 |                     |

From AWS Filler Metal Specifications: A5.4, A5.9, A5.22

a = Welding not recommended.