

Quick Welding Procedure

Base Material:	SA-312 Gr. TP304	to:	SA-790 (S31500)
Alloy Designation:	S30400		S31500
Principal Composition:	18Cr-8Ni		18Cr-5Ni-3Mo
P-Number:	8		10H
Group No.:	1		1
Preheat Temperature:	10 C (50 F)		
Filler Wire (GTAW):	ER309		
F-Number:	6		
A-Number:	8		
AWS:	5-9		
Interpass temperature:	150 C (300 F)		
Electrode (SMAW):	E309-16 /-15		
F-Number:	5		
A-Number:	8		
AWS:	5-4		
Postweld Heat Treatment:	None		
General Comments:	Alternate filler material is ER/E-NiCrFe-2 or -3. When one of the material to be joined is ferritic, consider buttering 12 mm on the ferritic side with the electrode /filler specified and perform heat treatment. In this case, no pre-heat or PWHT is required.		