

PREQUALIFIED WELDING CONSUMABLES
Reference Source Australian Standards AS/NZS 1554.6:1994 * † ‡

To	Weld	To	304	304L	309	310	316	316L	317	317L	316Ti	321	347	30815 (253MA)	904L	08028	4003	405	409	4105	430	444	410	403	420	31803	32304	32750	Nickel Alloys
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Austenitic Grades																													
304	308 §																												
304L	308	308L §																											
309	308	308	309 §																										
310	308	308	309	310																									
316	308	308	316	316	316 §																								
316L	308	308L	316	316	316	316L §																							
317	308	308	309	317	316	316	317	317																					
317L	308	308L	309	317	316	316L	317L	317L §																					
316Ti	308	308L	316	318	318	318	318	318	318	318	318																		
321	347	347	347	347	347	347	347	347	347	347	347 §																		
347	308	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347	347
30815 (253MA)	308	308	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT	22.12HT
904L	308	308L	309	309	316	316L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L	904L
08028	308	308L	309	309	316	316L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L	028L

Ferritic Grades																													
4003	316L	316L	309	309	316L	316L	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309
405	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309
409	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309
4105	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309
430	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309
444	316L	316L	316L	316L	316L	316L	316L	316L	316L	316L	316L	316L	316L	316L	316L	316L	309 ¶	309 ¶	309 ¶	309 ¶	309 ¶	309 ¶	309 ¶	309 ¶	309 ¶	309 ¶	309 ¶	309 ¶	309 ¶

Martensitic Grades																													
410	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309
403	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309
420	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309	309

Duplex Grades																													
31803	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209
32304	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209	2209
32750	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510	2510

Nickel Alloys																														
Nickel Alloys	309	309L	309	309	309Mo	309Mo	309Mo	309Mo	309Mo	309Mo	309	309	22.12HT	904L	028L	309L	309	309	309	309	309	309Mo	309	309	309	309	2209	2209	2510	NiCr3

Carbon Steel																														
Carbon Steel	309	309L	309	309	309	309Mo	309Mo	309Mo	309Mo	309Mo	309Mo	309	309	309Mo	309Mo	309Mo	309Mo	309	309	309	309	309Mo	309	309	309	309	2209	2209	2510	NiCr3

To	304	304L	309	310	316	316L	317	317L	316Ti	321	347	30815 (253MA)	904L	08028	4003	405	409	4105	430	444	410	403	420	31803	32304	32750	Nickel Alloys
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Notes to Table:

- * The recommended prequalified consumable for welding one grade to itself, i.e. similar metal welding, is given in bold
- † For dissimilar metals, welding the grade listed at the intersection of the row and column is recommended. Both this grade and the grade in bold on the intersecting row are prequalified, e.g. for welding 316L to 304L, both 308L and 316L are prequalified.
- ‡ For parent metals designations, refer to AISI, UNS or SEW designations, as appropriate. For welding consumables designations, refer to AS 1167.2, AS 1553.3, AS 2717.3, ANSI/AWS A5.4 or ANSI/AWS A5.9, as appropriate.
- § Silicon containing designations in accordance with AS 2717.3 is also deemed prequalified.
- || Also applies to grades 201, 202, 301, and 302
- ¶ Grade 316L is not prequalified for these dissimilar joints.
- Reference Source: Australian Standards AS/NZS 1554.6:1994
- Some common grades used in refractory applications.
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