This chart is only a suggestion of which filler metals should be adequate for the joining of the stainless steels. This does not mean that other filler metal alloys are not recommended or of less quality. In all instances the chart should be used as a reference only. Actual application should dictate the proper alloy choice.

The gray sections of the chart indicate “free-matching” alloys, which are considered not weldable. This is due to the high percentage of sulfur or other low melting point elements that cause hot cracking. If high-quality joints are required welding is not generally recommended.

This chart does not indicate welding procedure. Some stainless steels require preheat while others should not have a preheat. Some welds require a buttering layer or other more rigid procedure. Suppliers may be contacted regarding procedure recommendations.