

**Standard Welding Procedure
Specification (SWPS) for**

**Shielded Metal Arc
Welding of Austenitic
Stainless Steel (M-8/
P-8/S-8, Group 1),
10 through 18 Gauge,
in the As-Welded
Condition, with or
without Backing**

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An American National Standard

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Reaffirmed: March 11, 2013

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Prepared by the
American Welding Society (AWS) B2 Committee on Procedure and Performance Qualification

Under the Direction of the
AWS Technical Activities Committee

Approved by the
AWS Board of Directors

Abstract

This standard contains the essential welding variables for welding austenitic stainless steel in the thickness range of 18 through 10 gauge using manual shielded metal arc welding. It cites the base metals and operating conditions necessary to make the weldment, the filler metal specifications, and the allowable joint designs for fillet welds and groove welds.



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