



Nevatia Steel & Alloys Pvt. Ltd.
Office : 904,Lodha Supremus,9th floor
Worli, Mumbai ,India - 400018.
Web:<http://www.nevatiasteel.com>



TD-Stainless Welding wire
Revision No.: 02
Date of Issue : 01.11.2019

IATF 16949 , ISO 9001, ISO 14000 and ISO 45001 Certified Company

Stainless steel welding wire -Technical data

Product Name : nevinox®308L

Product Specifications : ER 308L

Grade	Equivalent Standards		
	AWS A5.9/5.9M	EN ISO 14343 A	EN ISO 14343 B
ER 308L	ER 308L	19 9 L	308L

Characteristics : ER308L is austenitic Stainless steel welding wire, the weld metal contains ferrite and resistance to crack is extremely good. Low carbon assists austenitic arc stability and improves corrosion resistance such as intergranular type. The mechanical properties of the weld metal are good.

Application : ER 308L welding wire of low carbon 19%Cr-9%Ni steel for Automobiles and Chemical Industries such as oil, Medical, Fertilizer Textile and Railway Industries and For Nuclear reactors. Designed for welding SS 301, 302, 304, 304L, 308 and 308L grades.

Chemical Composition % (Solid wire)

C	Mn	P	S	Si	Cr	Ni	Mo	Cu
0.03	1.30 - 2.10	0.030	0.020	0.30 - 0.65	19.50 - 21.00	9.00 - 11.00	0.30	0.30

Remarks: Single values shown in the table are maximum values. Two values shown indicate minimum and maximum limits for a range.

Typical All weld Mechanical properties

Product	Grade	Shielding Gas	N/mm ²		% EL (GL=50mm)	Impact Value (Joules)			
			YS (0.2% PT)	TS		-20°C	-60°C	-101°C	-196°C
MIG	ER 308L	I1	437	645	41	-	-	-	67

Current Conditions:- DC (+)

Welding position:-





Nevatia Steel & Alloys Pvt. Ltd.
Office : 904,Lodha Supremus,9th floor
Worli, Mumbai ,India - 400018.
Web:<http://www.nevatiasteel.com>



TD-Stainless Welding wire
Revision No.: 02
Date of Issue : 01.11.2019

IATF 16949 , ISO 9001, ISO 14000 and ISO 45001 Certified
Company

Dimension & Packing Data

Size(mm)	Size(inch)	SD100 Spool packing 1kg/2lb	SD200Spool packing 5kg/10lb	SD300/BS300 Spool packing 12.5kg,15kg /25lb, 33lb	Drum packing 100kg,250kg/ 200lb, -550 lb
0.600	0.024	√	√	-	-
0.800	0.030	√	√	√	√
0.900	0.035	√	√	√	√
1.000	0.040	√	√	√	√
1.200	0.045	√	√	√	√
1.600	0.063	-	√	√	√

Diameter tolerance and ovality

- As per AWS A5.9 and ISO 544

Inspection & certification

- As per EN 10204 type 3.1

For more details please contact : sales@nevatiasteel.com.