



Nevatia Steel & Alloys Pvt. Ltd.  
Office : 904,Lodha Supremus,9<sup>th</sup> 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®SAW308L

**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 is a 20 Cr / 10 Ni stainless steel submerged arc welding consumable similar in composition to ER 308L, suitable for welding in combination with SAW flux for austenitic stainless steels such as 18 Cr/ 8 Ni type, AISI 304, 304L, 308, 308L, 321 and 347 type of steels.

### **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**

Data is not presented, as submerged -arc is dependent on the type of flux used



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## Dimension & Packing Data

Size(mm)	Size(inch)	Packing
1.600 to 5.000	0.062 to 0.196"	K415 Basket spool - 25 Kg wire

## Diameter tolerance and ovality

- As per AWS A5.9 and ISO 544

## Inspection & certification

- As per EN 10204 type 3.1

## Approvals :



For more details please contact : [sales@nevatiasteel.com](mailto:sales@nevatiasteel.com).