



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[®]TIG308L

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

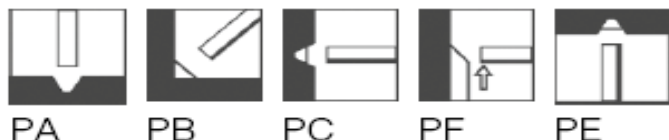
Remarks: Single values shown in the table are maximum values. Two values shown indicate minimum and maximum limits for a range.

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
TIG	ER 308L	I1	495	620	37	-	-	-	103

Current Conditions:- DC (-)

Welding position:-





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Dimension & Packing Data

Size(mm)	Size(inch)	Length (mm)	Length (inch)	Tube packing 5 kg/10lb	Box packing 20/25 kg / 50 lb
0.90	0.035	1000	36"	√	√
1.00	0.040	1000	36"	√	√
1.20	0.045	1000	36"	√	√
1.60	1/ 16"	1000	36"	√	√
2.00	5/ 64"	1000	36"	√	√
2.40/2.50	3/ 32"	1000	36"	√	√
3.15/3.20	1/ 8"	1000	36"	√	√
4.00	5/ 32"	1000	36"	√	√
5.00	3/ 16"	1000	36"	√	√

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.