



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[®]MIG309L

Product Specifications : ER 309L

| Grade | Equivalent Standards | | |
|---------|----------------------|----------------|----------------|
| | AWS A5.9/5.9M | EN ISO 14343 A | EN ISO 14343 B |
| ER 309L | ER 309L | 23 12 L | 309L |

Characteristics: ER 309L is austenitic Stainless steel welding wire, the weld metal contains ferrite and resistance to crack is extremely good. Due to its high level of alloy, it has excellent resistance to heat.

Application:

ER 309L welding wire of 22%Cr-12%Ni steel for joining ferrite to austenite stainless steel for services temperature up o 300°C . Heat resistance cast steel clad side of 18% Cr-8% Ni clad steel and stainless steel to Cr-Mo steel or carbon steel.

Chemical Composition % (Solid wire)

| C | Mn | P | S | Si | Cr | Ni | Mo | Cu |
|------|-------------|-------|-------|-------------|---------------|---------------|------|------|
| 0.03 | 1.40 - 2.10 | 0.030 | 0.020 | 0.30 - 0.65 | 23.00 - 25.00 | 12.00 - 14.00 | 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.

Current Conditions:- DC (+)

Welding position:-



PA PC PF PE



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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.