



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®SAW309L

**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 :** For joining carbon or mild alloy steel to austenitic stainless steels, Can also be used on "18-8" steels, since it overmatches the corrosion resistance, if the weldment will not be exposed to temperatures of 538° C to 927° C (1000° F to 1700° F), Ideal for joining stainless steels to themselves or to carbon or low alloy steels, and can be used at temperatures up to 700°F (371°C)

### **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.

### **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).