



Nevatia Steel & Alloys Pvt. Ltd.
Office : 904,Lodha Supremus,9th floor
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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®TIG309L

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: ER309L 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 to 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

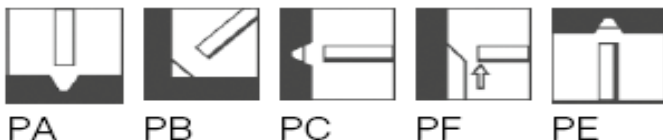
Remarks: Single values shown in the table are maximum values. Two values shown indicate minimum and maximum limits for a range.

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 309L	I1	454	633	41	209	-	-	-

Current Conditions:- DC (-)

Welding position:-



PA

PB

PC

PF

PE



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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

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