



308L, 316L and 309L

Stainless Steel submerged arc welding wires

Stainless Steel alloy solid wires for use in combination with Semi basic agglomerated submerged arc fluxes.

International Standards

	ISO 14343 - A - :2007	AWS A5.9-93
308L	S 19 9 L	ER308L
316L	S 19 12 3 L	ER316L
309L	S 23 12 L	ER309L

Typical Wire Analysis (wt%)

	C	Si	Mn	Cr	Ni	Mo
308L	0.01	0.4	1.9	19.5	10.5	-
316L	0.01	0.4	1.8	18.5	11.5	2.6
309L	0.03	0.6	1.9	23.5	12.5	-

Mechanical Properties

Dependant upon flux wire combination.

Materials

308L	All 300 series Austenitic Stainless Steels, Particularly AISI 304
316L	All 300 series Austenitic Stainless Steels, Particularly AISI 316 and 316L
309L	Dissimilar joints between all 300 series to its self and to mild steel, Austenitic Manganese steels, Cromweld 3Cr12

Packaging

Size mm	1.6	2.4	3.2	4.0
25 kilo	✓	✓	✓	✓
250 kilo Pops	✓	✓	✓	✓

Additional Information

Certification	BS EN 10204:2004 Type 3.1
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