

RONOX-308L

STAINLESS STEEL CONTINUOUS & CUT LENGTH
SOLID WELDING WIRE FOR MIG/TIG WELDING

BASIC ALLOY: FE, CR, NI
AWS/SFA-5.9: ER308L, BS 19.9.L
EN ISO 14343-A 19 9 L

KEY FEATURES:

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

APPLICATIONS

- Automobiles and Chemical Industries
- Fertilizer Textile and Railway Industries
- Oil, Medical
- SS 301, 302, 304, 304L, 308, 308L, 321 and 347 grades

SHEILDING GAS:

- welding with 100% Ar gas Or Ar+2%O2 gas

CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.030 max.	1.00-2.50	0.30-0.65	0.030 Max	0.030 Max	9.00-11.00	19.50-22.00	0.75 max	0.75 Max

MECHANICAL PROPERTIES:

UTS (N/mm)	Proof strength (N/mm2)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @	FERRITE Qty.(FN)
520-660	360-450	35-45	+20C : 100-150 J -196C : 50-70 J	8-10

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR MIG WELDING)

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min	Spool packing 12.5 kg	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	✓	✓	X
1.20	0.047	150-300	24-34	15-25	✓	✓	✓
1.60	1/16"	150-350	28-36	15-30	✓	✓	✓

DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR TIG WELDING)

Size (mm)	Size (inch)	Length (mm)	Length (Inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	40-80	10-16	✓	✓
2.0	5/ 64"	1000	36"	50-100	12-18	✓	✓
2.4/ 2.5	3/ 32"	1000	36"	60-120	14-20	✓	✓
3.2	1/ 8"	1000	36"	100-150	16-24	✓	✓
4.0	5/ 32	1000	36"	140-200	18-28	✓	✓