



SWASTIK-WELD

## JINIK MARKETING

### Swastik Weld Make Welding Wire GMAW/GTAW (MIG & TIG) for Stainless Steel

#### II) ER 309L CLASSIFICATION : AWS A/SFA 5.9:

##### Chemical Composition of ER 309L Wire:

C= 0.03 max

Mn= 1.0-2.5

Si= 0.30-0.65

##### PHOTO

Cr= 23.0-25.0

Ni= 12.0-14.0

Mo= 0.75 max

S= 0.03 max

P= 0.03 max



##### MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS, Mpa= 520 min

EL%= 30 min

##### TYPICAL APPLICATION OF ER 309L WIRE (MIG & TIG):

- 1) An extra low carbon 23Cr/12Ni type stainless steel wire for welding of AISI 309, 309L type steels
- 2) Dissimilar joints between stainless steels and low alloy or carbon steels
- 3) Buffer layer on low alloy and carbon steels
- 4) Joining corrosion resistant clad steels

Packing: Tig: In cut length of 1000mm in 5kgs boxes (size: 1.6, 2.0, 2.40, 3.15mm)

Mig: Continuous wire in 12.5kgs / 15kgs Plastic Spool (size: 0.80, 1.2mm)

Works: Gala No. 19, Syndicate Indl. Complex, Near Golani Naka, Near Bank of Maharashtra, Wallive Road, Vasai (E), Dist. Thane - 401 208.

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