



SWASTIK-WELD

**JINIK MARKETING**

**Tig Mig Stainless Steel Filler Wire**

Product: **Swastik Weld (AWS A 5.9)**

| Grade             | Typical All weld Deposit Analysis (%) |      |      |       |       |               | Typical All Weld Mechanical Properties |                        |            | Applications                                                                                                                                                                                                   |
|-------------------|---------------------------------------|------|------|-------|-------|---------------|----------------------------------------|------------------------|------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|                   | C                                     | Si   | Mn   | Cr    | Ni    | Mo            | Y.P.<br>N/mm2<br>(Ksi)                 | T.S.<br>N/mm2<br>(Ksi) | El.<br>(%) |                                                                                                                                                                                                                |
| ER-308L           | 0.03                                  | 0.48 | 1.67 | 19.22 | 9.77  | -             | -                                      | 570<br>(83)            | 41         | For low carbon of 18% Cr -8% Ni stainless steel.                                                                                                                                                               |
| ER-309L           | 0.03                                  | 0.47 | 1.47 | 23.50 | 13.41 | -             | -                                      | 570<br>(83)            | 40         | For low carbon of 22% Cr- 12% Ni stainless steel.and dissimilar steels welding.                                                                                                                                |
| ER-309LMo         | 0.014                                 | 0.50 | 1.75 | 24.10 | 12.9  | 2.40          |                                        |                        |            | Used for joining unalloyed/lowalloy steels/ cast steel grades or stainless steels/ heat-resistance chromium steels/ cast steel grades to austenitic steels/ cast steel grades as well as for overlay cladding. |
| ER-310            | 0.10                                  | 0.47 | 1.82 | 26.50 | 21.08 | -             | 420<br>(61)                            | 580<br>(84)            | 37         | For welding type AIS 1 310, 304 clad stainless steel.                                                                                                                                                          |
| ER-316L           | 0.03                                  | 0.46 | 1.73 | 19.20 | 12.50 | 2.47          | -                                      | 550<br>(80)            | 41         | For low carbon of 18% Cr-8% Ni - 2.5% Mo stainless steel.                                                                                                                                                      |
| ER-318            | 0.045                                 | 0.52 | 1.86 | 18.95 | 11.75 | 2.45          |                                        |                        |            | Use for welding of Base Metal Grade of 316Ti                                                                                                                                                                   |
| ER-347<br>ER-347L | 0.03                                  | 0.41 | 1.68 | 20.22 | 9.87  | Cb&Ta<br>0.88 | 450<br>(65)                            | 616<br>(89)            | 39         | For welding 321 and 347. Niobium stabilized reduce chance of chromium carbide precipitation and consequent intergranular corrosion.                                                                            |

**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.

**Email:** [swastikweld@gmail.com](mailto:swastikweld@gmail.com),

**Skype:** kamal.mehta14, **Mobile:** +91 9321434296, [www.jinikmarketing.com](http://www.jinikmarketing.com)