

Wires for Submerged Arc Welding of Stainless Steels

STAINLESS STEEL SOLID WIRES

CLASSIFICATION :

Product	EN ISO 14343-A	AWS A/SFA 5.9
SUBINOX 308L	S 19 9 L	ER308L
SUBINOX 316L	S 19 12 3 L	ER316L
SUBINOX 309L	S 23 12 L	ER309L
SUBINOX 347	S 19 9 Nb	ER347
SUBINOX 410	S 13	ER410
SUBINOX 410NiMo	S 13 4	ER410NiMo
SUBINOX 430	S 17	ER430
SUBINOX 2209	S 22 9 3 NL	ER2209
SUBINOX 2553		ER2553
SUBINOX 2594		ER2594

KEY FEATURES :

- Smooth feeding
- Close dimensional tolerances
- Controlled Chemistry

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% (Typical, Including Cu in coating):

Product	C	Mn	Si	Cr	Ni	Mo	Other Elements
SUBINOX 308L	0.025	1.50	0.40		9.3	--	--
SUBINOX 316L	0.025	1.50	0.40		11.5	2.2	--
SUBINOX 309L	0.025	1.50	0.40		12.2	--	--
SUBINOX 347	0.03	1.50	0.30	0.50	9.7	--	Nb + Ta – 0.60
SUBINOX 410	0.05	0.40	0.30	0.40	--	--	--
SUBINOX 410NiMo	0.03	0.40	0.30		4.5	0.45	--
SUBINOX 430	0.04	0.40	0.30		--	--	--
SUBINOX 2209	0.02	1.20	0.45		8.0	2.7	N – 0.12
SUBINOX 2553	0.02	0.60	0.40		5.5	3.5	Cu – 2.0
SUBINOX 2594	0.015	0.55	0.40		9.1	4.0	N – 0.25, W – 0.10

DIAMETERS - PACKING DATA :

PRODUCT	Ø, mm	Kg / Spool	Kg / Bobbin	SAWPAC DRUM, Kg
SUBINOX 308L	0.8, 1.2, 1.6, 2.0, 2.5, 3.15, 4.0, 5.0	0.8 to 1.6mm – 12.5 kg spool	2.0 to 5.0mm - 250	0.8 to 1.6 –
SUBINOX 316L				100 & 250
SUBINOX 309L				2.0 to 5.0 -
SUBINOX 347		1.6 to 5.0 – 25Kg Spool	2.0 to 5.0mm - 250	350 & 500
SUBINOX 410				
SUBINOX 410NiMo				
SUBINOX 430				
SUBINOX 2209				
SUBINOX 2553				
SUBINOX 2594				