

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 308L SPL	S 19 9 L	ER308L
SUBINOX 308H		ER308H
SUBINOX 316L	S 19 12 3 L	ER316L
SUBINOX 309L	S 23 12 L	ER309L
SUBINOX 309L Mo		ER309L Mo
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 2594		ER2594

KEY FEATURES :

- Smooth feeding
- Close dimensional tolerances
- Controlled Chemistry

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

Product	C	Mn	Si	Cr	Ni	Mo	Other Elements
SUBINOX 308L	0.025	1.50	0.40	19.5	9.3	--	--
SUBINOX 308L SPL	0.025	1.50	0.40	19.5	9.7	--	--
SUBINOX 308H	0.05	1.50	0.40	19.5	9.2	--	--
SUBINOX 316L	0.025	1.50	0.40	18.5	11.5	2.2	--
SUBINOX 309L	0.025	1.50	0.40	23.5	12.2	--	--
SUBINOX 309L Mo	0.025	1.50	0.40	23.5	12.2	2.2	--
SUBINOX 347	0.03	1.50	0.30	19.8	9.7	--	Nb + Ta – 0.60
SUBINOX 410	0.05	0.40	0.30	12.0	--	--	--
SUBINOX 410NiMo	0.03	0.40	0.30	12.0	4.5	0.45	--
SUBINOX 430	0.04	0.40	0.30	16.0	--	--	--
SUBINOX 2209	0.02	1.20	0.45	22.5	8.0	2.7	N – 0.12
SUBINOX 2594	0.015	0.55	0.40	25.2	9.1	4.0	N – 0.25, W – 0.10

WIRES FOR SUBMERGED ARC WELDING OF STAINLESS STEELS



STAINLESS STEEL SOLID WIRES

DIAMETERS - PACKING DATA :		
Product	Ø, mm	Kg / Spool
SUBINOX 308L	1.2, 1.6, 2.0, 2.5, 3.2, 4.0, 5.0	1.2 to 1.6 mm –
SUBINOX 308L SPL		
SUBINOX 308H		12.5 kg
SUBINOX 316L		spool
SUBINOX 309LMo		2.0 to 5.0 –
SUBINOX 309L		
SUBINOX 347		25 kg
SUBINOX 410		Spool
SUBINOX 410NiMo		
SUBINOX 430		
SUBINOX 2209		
SUBINOX 2594		