



Inoxfil, S.A.U.



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INOXFIL S.A.U. manufactures welding material with an optimal chemical composition and mechanical properties.

The material can be delivered with dull or bright surface, suitable for each client in order to ensure high reliability and good arc stability in all welding processes such as semiautomatic and automatic.

Inoxfil welding wire packages cover all possible needs of the clients.

Welding wire



Range of diameters

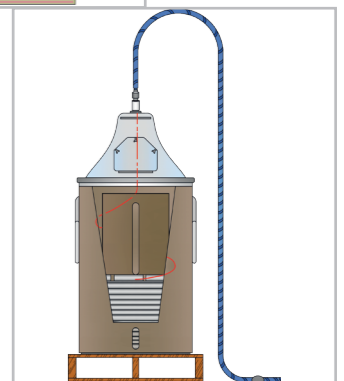
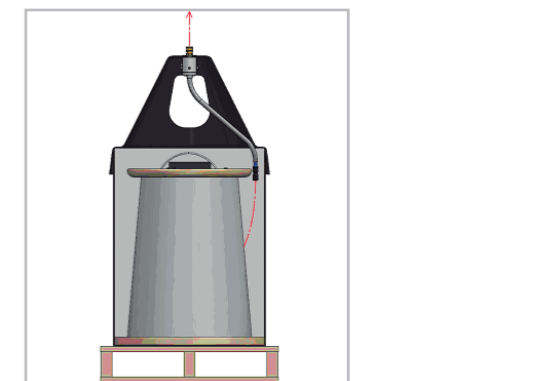
Welding	0.80	1.00	1.20	1.60	2.00	2.40	3.20	4.00
MIG/MAG (GMAW)								
TIG (GTAW)								
SUBMERGED ARC								
ELECTRODES	1.60- 5.00							

Tensile strength (Rm)

Welding		Rm N/mm ²
MIG/MAG (GMAW)	TIG (GTAW)	1000- 1700
SUBMERGED ARC	ELECTRODES	800- 1000

Packaging

Product	Packaging	Capacity (kg)
MIG/MAG (GMAW)	Plastic /metallic spool SD-300/BS300	15
	Plastic spool S-200	5
	Blue, Black metallic spools. etc (BS 300)	15
	Conical Metallic spool (4X) Wooden Spool (4XM)	300- 350
TIG	50 mm Diameter tubes	5
	Rectangular boxes	5
ELECTRODES	Coils	500- 1000
SUBMERGED ARC	Metallic spool K-415 y K-435	25



Welding wire

AWS: A5.9	EN 14343-A	ACX	STEEL No	PROPERTIES
ER 308L	19 9 L	602	1.4316	It is a CrNi type, for submerged arc welding (SAW) and welding with rods (TIG). Its use for stainless steels 18Cr8Ni type is recommended. It is a low carbon wire welding providing good resistance to intergranular corrosion, eliminating the precipitation of chromium carbides. It is often used as small bar for coated electrodes.
ER 308L	19 9 L	603	1.4316	It is a CrNi type, for submerged arc welding (SAW) and welding with rods (TIG). Its use for stainless steels 18Cr8Ni type is recommended. It is a low carbon wire welding providing good resistance to intergranular corrosion, eliminating the precipitation of chromium carbides.
ER 308LSi	19 9 LSi	605	1.4316	It is a welding wire for MIG/MAG (GMAW) recommended for steels containing approximately 19Cr10Ni, such as AISI 304, 304L. The high silicon content improves arc stability, fluidity and appearance of the weld seam. Resistance of welding to hot crack sensitivity (hot cracking) is better with higher than with lower silicon content.
ER 316L	19 12 3 L	652	1.4430	It is a CrNiMo welding wire type, for submerged arc welding (SAW) and welding with rods (TIG), recommended for welding AISI 316, AISI 316L types. Its low carbon eliminates the possibility of the formation of chromium carbides and increases the resistance to intergranular corrosion of the weld. It is often used as small bar for coated electrodes.
ER 316L	19 12 3 L	653	1.4430	It is a CrNiMo welding wire type, for submerged arc welding (SAW) and welding with rods (TIG), recommended for welding AISI 316, AISI 316L types. Its low carbon eliminates the possibility of the formation of chromium carbides and increases the resistance to intergranular corrosion of the weld.
ER 316LSi	19 12 3 LSi	655	1.4430	It is recommended for MIG/MAG (GMAW) welding of corrosion resistant steels like 18Cr12Ni3Mo and other similar steels such as AISI types 316L. Resistance of welding to hot crack sensitivity (hot cracking) is better with higher than with lower silicon content. The high silicon content improves arc stability, fluidity and appearance of the weld seam.
"ER 307LSi"	18 8 Mn	682	1.4370	It is recommended for MIG/MAG (GMAW) welding of dissimilar steels such as 18-8 steel with carbon steel and for joining steels difficult to weld. This type of material is used mainly in the automotive industry in welded joints of exhaust systems. Manganese improves the characteristics of resistance to mechanical friction, provides excellent toughness and high impact strength, abrasion and corrosion resistances. It allows a good finish of the cord without projections.
"ER 430Nb"		525	1.4511	It is a welding wire of ferritic structure basically used in the automotive industry for welding exhaust system. Its use is recommended for ferritic stainless steels welding.
ER 309L	"23 12 L"	709	(1.4332)	It is commonly used for welding similar alloys, but in some cases it can be used to weld the type 18Cr8Ni to bases of the same or similar metal, where severe conditions of use exist, and corrosion problems may appear, thereby requiring high alloyed weld metal. This type can also be used to weld types 18Cr8Ni with carbon steel or low alloy steels, dissimilar metals.
ER 309LSi	"23 12 LSi"	732	(1.4332)	This type of steel is similar to ER 309L but with higher silicon content in chemical composition. The high silicon content improves arc stability, fluidity and appearance of the weld seam. ER 309LSi can be used, as ER 309L, welding types 18Cr8Ni with carbon steel or low alloy steels, dissimilar metals.
ER 2209	22 9 3 N L	609	(1.4462)	It is a highly alloyed wire with Cr and Mo, specially designed for carrying out welds of similar duplex types. The properties of the duplex types and in particular the Cr and Mo contents of this alloy provide, in the welding seam, excellent high resistance to general, pitting and stress corrosion.

AWS: A5.9	EN 14343-A	ACX	STEEL No	PROPERTIES
"ER 318Si"	19 12 3 Nb Si	618	1.4576	It is a stabilized type with Nb, used for MIG welding and welding with rods (TIG) It is a suitable wire for welding CrNiMo, and CrNiMo with Ti or Nb materials, and it is recommended in environments where good resistance to corrosion is needed, as for food and chemical industries.
ER 310	25 20	610	1.4842	It is designed for welding similar austenitic refractory types 25Cr/20Ni, is used to resist corrosion and oxidation at high temperatures, it can withstand flacking up to 1000°C and it can be used for MIG welding (GMAW), TIG (GTAW), and submerged arc welding (SAW).
ER 347Si	19 9 Nb Si	647	1.4551	It is stabilized with Nb and designed for welding austenitic stainless steels 18Cr /10Ni stabilized with Nb or Ti types, that can also be used to weld unstabilized types. It is indicated for places where you need an excellent resistance to intergranular corrosion, the Nb content gives this property.
(ER309LMo)	23 12 2 L	710	1.4459	This type of steel has a chemical composition similar to ER 309L but with the addition of Mo in environments of 2.00-3.00% approx. The high content of Molybdenum improves the behaviour of the material against pitting corrosion in chlorinated environments. ER 309L Mo is used for dissimilar welding between stainless steels and low alloy steels, as well as for overlapping liners, base metal liners to improve their resistance to corrosion. Used to achieve a liner with a chemical composition similar to an AISI 316L type. Used as filler metal for the first liner layer in multi-layers with filler metals such as AISI 316L or AISI 317L. In some cases it can be used to weld type 18Cr8Ni with bases of the same or similar metal where there are severe conditions of use and corrosion problems may occur, thus requiring a high alloy in the welded metal. According to its presentation, the material can be applied in different welding processes, such as TIG (GTAW) or MIG/MAG (GMAW).
ER 310S	25 20	610S	1.4845	ER 310S is an austenitic chromium nickel stainless steel. It has a good behaviour working in high temperatures continuous service up to 1095°C. It has a good oxidation resistance in these conditions and is also used for intermittent service at temperatures up to 1030°C. It has a low coefficient of thermal expansion. Alloy 310S can be used in cryogenic applications with low magnetic permeability and toughness down to -230°C. Alloy 310S is similar to alloy 310 except for lower carbon content to minimize carbide precipitation during welding.
(ER312)	29 9	712	1.4337	The 29 9 type has been designed for welding dissimilar alloys, carbon steels with high Ni stainless steels. High resistance to hot cracking. ACX 712 provides a two-phase weld deposit with a high percentage of ferrite in an austenitic matrix.

