



WELDING STAINLESS STEELS


RODACCIAI REFERENCES AND COMPARABLE STANDARDS

	EN ISO 14343-A: 2009	EN ISO 14343-B: 2009	AWS A5.9-2012	DIN Werkstoff Nr.
RW 307	18 8 Mn	-	-	1.4370
RW 307L	18 8 Mn	-	-	1.4370
RW 307Si	18 8 Mn	-	-	1.4370
RW 308L	19 9 L	SS308 L	-	-
RW 308L AWS	19 9 L	SS308 L	ER308L	1.4316
RW 308LSi	19 9 L Si	SS308 LSi	ER308LSi	1.4316
RW 308H	19 9 H	SS308 H	ER308H	-
RW 309L	23 12 L	SS309 L	ER309L	1.4332
RW 309Si	-	SS309 Si	ER309Si	(1.4829)
RW 309LSi	23 12 L Si	SS309 LSi	ER309LSi	1.4332
RW 309LMo	23 12 2 L	-	-	(1.4459)
RW 310	25 20	SS310	ER310	(1.4842)
RW 312	29 9	SS312	ER312	1.4337
RW 316L	19 12 3 L	SS316 L	ER316L	1.4430
RW 316L AWS	19 12 3 L	SS316 L	ER316L	1.4430
RW 316LSi	19 12 3 L Si	SS316 LSi	ER316LSi	1.4430
RW 316H	19 12 3 H	SS316 H	ER316H	-
RW 317L AWS	18 15 3 L	SS317 L	ER317L	-
RW 318Si	19 12 3 Nb Si	-	(ER318)	1.4576
RW 347	19 9 Nb	SS347	ER347	1.4551
RW 347Si	19 9 Nb Si	SS347 Si	ER347Si	1.4551
RW 385	20 25 5 Cu L	SS385	ER385	-
RW 2209	22 9 3 N L	SS2209	ER2209	(1.4462)
RW 410	13	SS410	ER410	-
RW 410NiMo	13 4	(SS410 NiMo)	(ER410NiMo)	-
RW 4122	-	-	-	1.4122
RW 420	-	SS420	ER420	-
RW 420C	-	(SS420)	(ER420)	1.4031
RW 430	(17)	SS430	ER430	1.4016
RW 430LNb	18 LNb	SS430 LNb	-	1.4511

WELDING STAINLESS STEELS
CHEMICAL COMPOSITION (BATCH ANALYSIS) %

		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N	Nb
RW 307	min	-	5,00	-	-	-	17,0	7,0	-	-	-	-
	max	0,08	8,00	0,50	0,030	0,030	20,0	10,0	0,30	0,30	-	-
RW 307L	min	-	5,00	0,30	-	-	17,0	7,0	-	-	-	-
	max	0,05	8,00	0,70	0,030	0,030	20,0	10,0	0,30	0,30	-	-
RW 307Si	min	-	5,00	0,65	-	-	17,0	7,0	-	-	-	-
	max	0,10	8,00	1,00	0,030	0,030	20,0	10,0	0,30	0,30	-	-
RW 308L	min	-	1,00	-	-	-	19,5	9,0	-	-	-	-
	max	0,03	2,50	0,20	0,020	0,030	21,0	11,0	0,30	0,30	-	-
RW 308L AWS	min	-	1,00	0,30	-	-	19,5	9,0	-	-	-	-
	max	0,03	2,50	0,65	0,020	0,030	21,0	11,0	0,30	0,30	-	-
RW 308LSi	min	-	1,00	0,65	-	-	19,5	9,0	-	-	-	-
	max	0,03	2,50	1,00	0,020	0,030	21,0	11,0	0,30	0,30	-	-
RW 308H	min	0,04	1,00	0,30	-	-	19,5	9,0	-	-	-	-
	max	0,08	2,50	0,65	0,020	0,030	21,0	11,0	0,30	0,30	-	-
RW 309L	min	-	1,00	0,30	-	-	23,0	12,0	-	-	-	-
	max	0,03	2,50	0,65	0,020	0,030	25,0	14,0	0,30	0,30	-	-
RW 309Si	min	-	1,00	0,65	-	-	23,0	12,0	-	-	-	-
	max	0,12	2,50	1,00	0,030	0,030	25,0	14,0	0,75	0,75	-	-
RW 309LSi	min	-	1,00	0,65	-	-	23,0	12,0	-	-	-	-
	max	0,03	2,50	1,00	0,020	0,030	25,0	14,0	0,30	0,30	-	-
RW 309LMo	min	-	1,00	0,30	-	-	21,0	11,0	2,00	-	-	-
	max	0,03	2,50	0,65	0,020	0,030	25,0	15,5	3,50	0,30	-	-
RW 310	min	0,08	1,00	0,30	-	-	25,0	20,0	-	-	-	-
	max	0,15	2,50	0,65	0,020	0,030	27,0	22,0	0,30	0,30	-	-
RW 312	min	-	1,00	0,30	-	-	28,0	8,0	-	-	-	-
	max	0,15	2,50	0,65	0,020	0,030	32,0	10,5	0,30	0,30	-	-
RW 316L	min	-	1,00	-	-	-	18,0	11,0	2,50	-	-	-
	max	0,03	2,50	0,20	0,020	0,030	20,0	14,0	3,00	0,30	-	-
RW 316L AWS	min	-	1,00	0,30	-	-	18,0	11,0	2,50	-	-	-
	max	0,03	2,50	0,65	0,020	0,030	20,0	14,0	3,00	0,30	-	-
RW 316LSi	min	-	1,00	0,65	-	-	18,0	11,0	2,50	-	-	-
	max	0,03	2,50	1,00	0,020	0,030	20,0	14,0	3,00	0,30	-	-

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CHEMICAL COMPOSITION (BATCH ANALYSIS) %

		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N	Nb
RW 316H	min	0,04	1,00	0,30	-	-	18,0	11,0	2,00	-	-	-
	max	0,08	2,50	0,65	0,020	0,030	20,0	14,0	3,00	0,30	-	-
RW 317L AWS	min	-	1,00	0,30	-	-	18,5	13,0	3,00	-	-	-
	max	0,03	2,50	0,65	0,020	0,030	20,0	15,0	4,00	0,30	-	-
RW 318Si	min	-	1,00	0,65	-	-	18,0	11,0	2,50	-	-	10xC
	max	0,08	2,50	1,00	0,020	0,030	20,0	14,0	3,00	0,30	-	1,00
RW 347	min	-	1,00	0,30	-	-	19,0	9,0	-	-	-	10xC
	max	0,08	2,50	0,65	0,020	0,030	21,0	11,0	0,30	0,30	-	1,00
RW 347Si	min	-	1,00	0,65	-	-	19,0	9,0	-	-	-	10xC
	max	0,08	2,50	1,00	0,020	0,030	21,0	11,0	0,30	0,30	-	1,00
RW 385	min	-	1,00	-	-	-	19,5	24,0	4,20	1,20	-	-
	max	0,025	2,50	0,50	0,020	0,020	21,5	26,0	5,20	2,00	-	-
RW 2209	min	-	0,50	-	-	-	21,5	7,5	2,50	-	0,10	-
	max	0,03	2,00	0,90	0,020	0,030	23,5	9,5	3,50	0,30	0,20	-
RW 410	min	-	-	-	-	-	12,0	-	-	-	-	-
	max	0,12	0,60	0,50	0,020	0,030	13,5	0,6	0,75	0,40	-	-
RW 410NiMo	min	-	-	-	-	-	11,0	4,0	0,40	-	-	-
	max	0,05	1,00	0,50	0,020	0,030	12,5	5,0	0,70	0,30	-	-
RW 4122	min	0,33	-	-	-	-	15,5	-	0,90	-	-	-
	max	0,43	1,00	0,70	0,020	0,030	17,5	1,0	1,20	-	-	-
RW 420	min	0,30	-	-	-	-	12,0	-	-	-	-	-
	max	0,40	0,60	0,50	0,030	0,030	14,0	0,6	0,75	0,75	-	-
RW 420C	min	0,38	0,30	-	-	-	12,0	-	-	-	-	-
	max	0,43	0,60	0,50	0,030	0,030	14,0	0,6	0,75	0,75	-	-
RW 430	min	-	-	-	-	-	16,0	-	-	-	-	-
	max	0,10	0,60	0,50	0,030	0,030	17,0	0,6	0,75	0,75	-	-
RW 430LNb	min	-	-	-	-	-	17,8	-	-	-	-	0,05+ 7(C+N)
	max	0,02	0,80	0,50	0,020	0,030	18,8	0,30	0,30	0,30	0,02	0,50

PRODUCTION RANGE AND FINISHING

WELDING PROCESSES		SIZE	PACKAGING																							
MIG	mm	0,60 - 0,80 - 0,90 - 1,00 - 1,20 - 1,60	Plastic spool D200 - size: width 55 mm - outside diameter: 200 mm - spindle hole diameter: 51,5 mm - weight: 5 Kg Plastic spool D300 - size: width 100 mm - outside diameter: 300 mm - spindle hole diameter: 51,5 mm - weight: 12,5 Kg (for diameter ≤0,8 mm) 15 Kg (for diameters >0,8 mm)																							
	inches	0.023 - 0.030 - 0.035 - 0.045 - 1/16	Blue metallic wire basket BS300 - size: width 100 mm - outside diameter: 300 mm - inside diameter: 51,5 mm - weight: 15 Kg Bulk spool / wood - size: width 285 mm - outside diameter: 750 mm - spindle hole diameter: 41 mm - weight: 250 Kg Drum for robotic welding <table border="1"> <tr> <td>- wire diameter (mm):</td> <td>0,8</td> <td>0,9</td> <td>1,0</td> <td>1,2</td> <td>1,6</td> </tr> <tr> <td>- height of drum (mm):</td> <td>620</td> <td></td> <td>810</td> <td></td> <td>810</td> </tr> <tr> <td>- outside diameter (mm):</td> <td>520</td> <td></td> <td>520</td> <td></td> <td>570</td> </tr> <tr> <td>- weight (Kg):</td> <td>150</td> <td></td> <td>250</td> <td></td> <td>250</td> </tr> </table>	- wire diameter (mm):	0,8	0,9	1,0	1,2	1,6	- height of drum (mm):	620		810		810	- outside diameter (mm):	520		520		570	- weight (Kg):	150		250	
- wire diameter (mm):	0,8	0,9	1,0	1,2	1,6																					
- height of drum (mm):	620		810		810																					
- outside diameter (mm):	520		520		570																					
- weight (Kg):	150		250		250																					
TIG	mm	0,80 - 1,00 - 1,20 - 1,60 - 2,00 2,40 - 3,20 - 4,00 - 5,00	Rods - length 1000 mm (Ø in mm)/36 inches (Ø in inches) - stamped with AWS and W.Nr. ref. - packed in neutral boxes or cardboard tubes - weight: 5 Kg																							
	inches	0.030 - 0.035 - 0.045 - 1/16 - 5/64 3/32 - 1/8 - 5/32 - 3/16																								
SUBMERGED ARC	mm	1,60 - 2,00 - 2,40 - 3,20 - 4,00	Metallic wire basket K415 - size: width 100 mm - outside diameter: 415 mm - inside diameter: 300 mm - weight: 25 kg Drum - wire diameter: 2,0 - 4,0 mm - height of drum: 850 mm - outside diameter: 660 mm - weight: 300 Kg																							
	inches	1/16 - 5/64 - 3/32 - 1/8 - 5/32																								
CORE WIRE IN CUT LENGTHS OR IN COILS	mm	1,60 - 2,00 - 2,50 - 3,25 - 4,00 - 5,00	Core wires in cut lengths - length 250 - 450 mm (9 - 18 inches) - packed in wooden crates sizes: - from 800 Kg, base 820x800 mm - height 540 mm - from 500 Kg, base 600x900 mm - height 550 mm Core wires in coils - size: internal diameter: 380 mm - weight: 500/800 Kg																							
	inches	1/16 - 5/64 - 3/32 - 1/8 5/32 - 3/16																								

rev. 04/2013

 STAINLESS STEELS
WELDING PRODUCTS

Rodacciai name

Welding stainless steels

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