



Stainless Steel Consumables for SMAW Welding

Product Name	ASME/AWS	Applications and Characteristics	Typical Chemical Analysis %		Typical Mechanical Properties	
					Tensile Strength MPa	EL %
RevoWel 308L-16	A5.4 E308L-16	REVOWEL 308L-16 is a lime titanium oxide type stainless steel covered electrode designed for welding type 304, 304L base material with low carbon content, depositing weld metal containing approximately 19%Cr-9%Ni.	C Mn Si Cr Ni	0.03 0.66 0.80 19.3 9.80	556	47
RevoWel 309L-16	A5.4 E309L-16	REVOWEL 309L-16 is a lime titanium oxide type covered electrode for low carbon content stainless steel, depositing weld metal containing approximately 23%Cr-13%Ni. This electrode is used primarily for welding type 316L and 316 clad steels, or dissimilar welding between carbon steel & stainless steel.	C Mn Si Cr Ni	0.03 1.20 0.72 23.7 13.40	570	39
RevoWel 309LMo-16	A5.4 E309LMo-16	REVOWEL 309LMo-16 is a lime titanium oxide type covered electrode for low carbon content stainless steel, depositing weld metal containing approximately 2.5%Mo. This electrode is used primarily for welding type 316L and 316 clad steels, or dissimilar welding between carbon steel & stainless steel.	C Mn Si Cr Ni Mo	0.03 1.25 0.63 22.89 12.94 2.5	650	40
RevoWel 316L-16	A5.4 E316L-16	REVOWEL 316L-16 is a lime titanium oxide type covered electrode for Type 316 low carbon content stainless steel, depositing weld metal containing approximately 18%Cr 12%Ni 2.0%Mo.	C Mn Si Cr Ni Mo	0.02 1.63 0.71 17/91 12.38 2.5	560	41
RevoWel 347-16	A5.4 E347-16	REVOWEL 347-16 is a niobium bearing rutile type covered electrode for Ta + Nb stabilized 18%Cr-8%Ni steel, especially for high temperature services. This electrode is used primarily for welding type 347 and 321 steel, the depositing weld metal containing Niobium which promotes good inter-granular corrosion resistance.	C Mn Si Cr Ni Mo	0.04 0.79 0.89 19.28 9.5 2.49	643	38

Stainless Steel Consumables for FCAW Welding

RevoCor 308LT1	A5.22 E308LT1-1/4	REVOCOR 308LT-1 is a rutile flux cored tubular wire for all-positional welding capable of depositing a nominal 18%Cr-8%Ni low carbon weld metal for the welding of stainless steels of similar composition. The weld metal provides a good resistance to inter-granular corrosion and is suitable for applications operating at temperatures up to 300°C.	C Mn Si Cr Ni	0.02 1.31 0.72 20.5 10.5	550 33J @ - 196C	45
RevoCor 308HT1	A5.22 E308HT1-1/4	RevoCor 308HT-1 is a rutile flux cored tubular wire for all-positional welding of types 304H and 347H stainless when high temperature service is required.	C Mn Si Cr Ni	0.06 1.42 0.72 19.9 9.4	565 34J @ - 196	34
RevoCor 309LT1	A5.22 E309LT1-1/4	REVOCOR 309LT1-1 is a gas shielded rutile flux cored wire for all-positional welding capable of depositing a low C - 23%Cr -12%Ni weld metal for welding joints between stainless steel to mild and medium tensile steels.	C Mn Si Cr Ni	0.03 1.20 0.5 22.2 12.8	586	38
RevoCor 309LMo	A5.22 E309LMoT1-1/4	REVOCOR 309LMo is a gas shielded rutile flux cored wire for all-positional welding capable of depositing a low C-23%Cr -12%Ni - 2.5%Mo weld metal for welding joints between stainless steel to mild and medium tensile steels.	C Mn Si Cr Ni Mo	0.02 0.90 0.74 23.4 13.2 2.6	660	31



RevoCor 316LT1	A5.22 E316LT1-1/4	REVOCOR 316LT-1 is a gas shielded rutile flux cored wire for all-positional welding capable of depositing a nominal low C-19%Cr-12%Ni-2.6%Mo weld metal for the welding of 316L grade stainless steels. Being a molybdenum bearing stainless steel provides good resistance to pitting corrosion and crevice corrosion in non-oxidising acids.	C Mn Si Cr Ni Mo	0.02 1.70 0.70 19.00 12.00 2.80	587 65J @ - 100C	30
RevoCor 316LT-PA	A5.22 E316LT0-1/4	REVOCOR 316LT-PA is a gas shielded rutile flux cored wire for flat & horizontal welding capable of depositing a nominal low C-19%Cr-12%Ni-2.6%Mo weld metal for the welding of 316L grade stainless steels. Being a molybdenum bearing stainless steel provides good resistance to pitting corrosion and crevice corrosion in non-oxidising acids.	C Mn Si Cr Ni Mo	0.037 1.13 0.67 18.16 12.17 2.5	520	38

Stainless Steel Flux for SAW Welding

REVOFLUX 330

REVOFLUX 330 is an agglomerated flux for welding austenitic stainless steel. It contains a well balance alloying element to maintain the stability of the ferrite in weld metal. It gives a high resistance to crack, corrosion and mechanical properties. The flux in combination with wire gives a good weldability, excellent slag detachability, and good smooth weld bead appearance. It is use in combination with stainless steel wire grade 308L, 316L, and 309L in submerged arc welding.

Classification: EN760 SA FB 2 AC
Grain Size: 10-60 Mesh
Basicity Index: 2.7

SiO ₂ +TiO ₂	Al ₂ O ₃ +MnO	CaO+MgO	CaF ₂
15.0	20.0	0.40	25.0

The flux must be bake at 300 ~350C for 1hours before use.

TYPICAL CHEMICAL ANALYSIS OF WELD-METAL (%)						
	C	Mn	Si	Ni	Cr	Mo
Revofil 308L	0.03	1.58	0.65	9.20	19.20	-
Revofil 309L	0.03	1.48	0.62	13.32	23.25	-
Revofil 316L	0.03	1.70	0.40	11.20	19.00	2.5

TYPICAL WELD-METAL MECHANICAL PROPERTIES			
	Tensile Strength (N/mm ²)	Elongation (%)	Charpy @ -196°C
Revofil 308L	≥510	≥30	≥40J
Revofil 309L	≥510	≥25	≥40J
Revofil 316L	≥510	≥25	≥40J



Stainless Steel Consumables for GTAW, GMAW and SAW Welding

Product Name	AWS A5.9 / EN 12072	Applications and Characteristics	Typical Chemical Analysis %		Typical Mechanical Properties	
					Tensile Strength MPa	EL %
Revofil 307Si		For welding on work-hardenable steels, armour plates, austenitic Mn steels and free-machining steels, e.g. 303. Also for stainless Cr steels with max. 18% Cr, e.g. in the automotive industry. Overlay welding of carbon and low-alloyed steels The corrosion resistance is similar to that of stainless the respective parent metal.	C Mn Si Cr Ni Mo	0.070 6.76 0.7 18.8 8.94 0.12	600	41
Revofil 308L	ER 308L EN 19 9 L	The weld metal is 18Cr-8Ni stainless steel. It is suitable for the welding of AISI 304, 304L, 301, 302 and 321.	C Mn Si Cr Ni	0.024 1.65 0.42 20.1 10.3	580	42
Revofil 308LSi	ER 308LSi EN 19 9 L Si	The weld metal with low carbon and higher silicon content improves the fluidity of the filler metal during welding.	C Mn Si Cr Ni	0.025 2.25 0.78 19.80 10.50	590	41
Revofil 309L	ER 309L EN 23 12 L	The weld metal contains high Ni and Cr. Suitable for the welding of dissimilar metals such as mild steel to stainless steel.	C Mn Si Cr Ni	0.023 1.98 0.39 23.9 12.90	590	40
Revofil 309LSi	ER 309LSi EN 23 12 L Si	The weld metal with low carbon and higher silicon content improves the fluidity of the filler metal during welding.	C Mn Si Cr Ni	0.024 2.35 0.74 23.9 13.80	600	38
Revofil 309LMo	(ER 309LMo) EN 23 12 2 L	The weld metal is low carbon 25Cr-12Ni-2.5Mo stainless steel. Excellent oxidization resistance at high temp. can be attained. Suitable for welding of dissimilar metals.	C Mn Si Cr Ni Mo	0.01 1.82 0.46 23.80 13.10 2.54	620	42
Revofil 310	ER 310 EN 25 20	Excellent corrosion resistance, heat resistance, and toughness. Suitable for the welding of steel with high hardenability, and 13Cr steel.	C Mn Si Cr Ni	0.09 2.01 0.40 27.40 21.80	610	41
Revofil 312	ER 312 EN 29 9	For welding of 29%Cr-9%Ni stainless cast steel. And dissimilar metal such as carbon steel or low alloy steel to stainless steel.	C Mn Si Cr Ni	0.13 1.62 0.49 29.6 8.70	710	26
Revofil 316L	ER 316L EN 19 12 3 L	For welding of 18%Cr-12%Ni-2%Mo stainless steel. Excellent creep strength and resistance to sulfuric acid due to the Mo content.	C Mn Si Cr Ni Mo	0.02 1.91 0.42 19.10 12.60 2.6	560	40
Revofil 316LSi	ER 316L EN 19 12 3 L Si	For welding of 18%Cr-12%Ni-2%Mo stainless steel. Excellent creep strength and resistance to sulfuric acid due to the Mo content.	C Mn Si Cr Ni Mo	0.02 1.91 0.80 19.10 12.60 2.6	560	40



Stainless Steel Consumables for GTAW, GMAW, SAW Welding

Product Name	AWS A5.9 / EN 12072	Applications and Characteristics	Typical Chemical Analysis %		Typical Mechanical Properties	
					Tensile Strength MPa	EL %
Revofil 317L	ER 317L EN 19 13 4 L	For welding of low carbon 19%Cr-13%Ni-3%Mo stainless steel. Excellent inter-granular corrosion resistance.	C Mn Si Cr Ni Mo	0.02 1.76 0.40 19.60 13.70 3.60	570	42
Revofil 318	ER318 EN 19 12 3 Nb	For welding stabilised austenitic stainless steel such as AISI318.	C Mn Si Cr Ni Nb Mo	0.04 1.85 0.40 18.9 13.0 0.80 2.53	640	37
Revofil 347	ER 347 EN 19 9 Nb	For welding of heat resistance steel. Excellent intergranular corrosion resistance due to Nb content, suitable for welding of AISI 347, 321, 304L.	C Mn Si Cr Ni Nb	0.04 1.61 0.41 20.40 9.9 0.80	630	41
Revofil 347Si	ER 347 EN 19 9 Nb Si	The weld metal is ultra low carbon and higher silicon content that improves the fluidity of the filler metal during welding.	C Mn Si Cr Ni Nb	0.02 1.9 0.8 19.2 9.9 0.52	665	37
Revofil 410NiMo	(ER 410NiMo) EN 13 4	For welding of soft Martensitic like DIN X5 Cr Ni 13 4 or similar in hydropower equipment. Surfacing the continuous casting rolls of the steel mills.	C Mn Si Cr Ni Mo	0.02 0.73 4.1 12.2 4.5 0.55	990	15
Revofil 410	ER 410 EN 13L	For welding of 13%Cr stainless steel such as AISI 410 and AISI 420.	C Mn Si Cr Ni	0.14 0.20 0.13 12.16 0.30	530	25
Revofil 904L	ER 385 EN 20 25 5 Cu L	For welding of stainless high-alloyed Ni-Cr-Mo-Cu grade 904L or other similar materials. Excellent resistance to stress corrosion cracking and intergranular corrosion as well as in non-oxidising acids, e.g. sulphuric, phosphoric. Also used for welding of clad steels or overlay on carbon steel.	C Mn Si Cr Ni Mo Cu	0.020 1.8 0.4 20 25 4.5 1.5	550	35
Revofil 2209	ER2209 EN 22 9 3NL	For welding of duplex stainless steels such as UNS31803, S31500, S31200, S32304. Excellent resistance to intergranular corrosion and pitting. Good resistance to stress corrosion cracking, especially in environments containing H ₂ S and chlorides.	C Mn Si Cr Ni Mo N	0.012 1.23 0.48 23.28 8.57 3.2 0.14	750	25
Revofil 2594	ER2594 EN 25 9 4NL	For welding of Superduplex stainless steel such as UNS32750, S32760. It is also use to weld UNS31803 duplex where higher corrosion resistance is required.	C Mn Si Cr Ni Mo N	0.013 0.40 0.30 25.10 9.50 4.0 0.26	850	27