MARCEGAGLIA
FAGERSTA STAINLESS

WIRE ROD FOR WELDING

Thanks to a company history starting already 1873, Fagersta Stainless belongs to one of the world leading producers of stainless wire rod and wire. With customized chemistries the products fulfill everything from simple to high demanding applications.

STANDARD STEEL GRADES FOR WELDING

Our grades have tight chemistries and therefore equal properties from delivery to delivery.
We recommend following of our standard grades:

OPTIMUM WIRE ROD FOR WELDING

To get best possible properties for welding wire rod, these parameters are important:

- Tight chemistry for identical properties
- Corrosion properties
- Surfaces
- Dimension tolerances

Grade family	Marcegaglia name	Fagersta	EN	ASTM		PRE	CWH	Typical chemical composition, % by mass					
				TYPE	UNS			C	Cr	Ni	Mo	N	Others
F	409Ti/4512	R109.11	1.4512	409TI	-	11	-	0.025*	11.3	-	-	-	Ti
F	430LNb	R258.10	18LNB	430Nb	-	19	-	0.02*	18.2	-	-	-	Nb
F	430NbTi/4016	R258.13	18 LNbTi	-	-	19	-	0.02*	18.2	-	-	-	Ti, Nb
A	30Nb/4511	R258.15	1.4511	430Nb	-	18	-	0.15	16.4	-	-	0.04	Nb
A	4551	R358.16	1.4551 / 19 9 NbSi	347Si	S34788	21	-	0.035	19.4	9.8	-	0.04	Nb
A	347H/4550/4551	R358.22	19 9 Nb	347/347H	-	21	-	0.05	19.6	9.2	-	0.03	Nb
A	308L/4316	R366.10	1.4316 / 19 9 L	308L	S30883	21	-	0.015*	19.7	10.2	-	0.05	-
A	308LSi/4316	R366.72	1.4316 / 19 9 Lsi	308L	S30888	21	-	0.023*	19.85	10.35	-	0.065	-
A	318/4576	R448.11	1.4576 / 19 12 3 Nb	318	-	29	-	0.04	19.3	11.6	2.6	0.04	Nb
A	318Si/4576	R448.12	19 12 3 NbSi	-	-	28	-	0.035	18.9	11.8	2.7	0.05	Nb
A	316L/4430	R466.10	19 12 3 L	316L	-	28	-	0.015*	18.3	12.2	2.6	0.04	-
A	316LSi/4430	R466.20	1.4430 / 19 12 3 LSi	316LSi	S31688	28	-	0.015*	18.3	11.8	2.6	0.04	-
A	317L	R476.25	18 15 3 L	317L	-	31	-	0.02*	18.8	13.7	3.6	0.05	-
A	16–8–2	R516.30	16 8 2	-	-	20	-	0.05	15.5	8.5	1.2	0.04	-
A	307L	R526.10	18 8 Mn	307	-	18	-	0.035	17.3	7.8	-	-	5.9Mn
A	307Si	R526.70	18 8 SiMn	307	-	19	-	0.08	18.2	8	-	-	7.0Mn
D	2209	R646.21	22 9 3 N L	2209	S39209	36	-	0.013*	23.0	8.75	3.15	0.16	0.012Al
D	2594	R647.73	25 9 4 NL	2594	-	42	-	0.015*	25.1	9.5	4	0.25	0.012Al
D	2507	R647.77	1.4410	-	-	43	-	0.02*	25.45	6.55	3.9	0.29	0.015Al
D	2307	R656.20	23 7 NL	2307	-	27	-	0.025*	23.5	7.7	-	0.14	-
D	2504	R656.30	25 4	-	-	26	-	0.070	25.3	4.5	-	-	-
D	312	R656.70	29 9	312 / 29-9	-	32	-	0.10	30.35	9.2	-	0.055	0.01Al
A	309L/4332	R806.20	1.4332 / 23 12 L	309L	S30983	26	-	0.018*	23.5	13.7	-	0.08	-
A	309LSi/4332	R806.24	1.4332 / 23 12 L Si	309L	S30988	27	-	0.025*	23.3	13.8	-	0.12	-
A	309LSi/4332	R806.42	1.4332 / 23 12 L Si	309L	S30988	26	-	0.015	23.5	13.6	-	0.08	-
A	309LNb4332	R806.45	23 12 L Nb	309LNb	-	25	-	0.013*	23.9	12.6	-	0.04	0.025Al 0.75Nb
A	309Si/4332	R806.72	22 12 H	-	-	25	-	0.09	23.35	12.75	-	0.055	-
A	309LMo/4459	R816.10	23 12 2 L	-	-	31	-	0.015*	21.45	15	2.7	0.06	-
A	904L	R840.21	1.4539	385	N08904	35	-	0.015*	20.00	25.00	4.50	0.05	1.5Cu
A	Alloy 825	R906.10	-	Alloy 825	-	33	-	0.025*	22.3	42.9	3.2	-	1.7Cu 0.7Ti
A	Alloy 601	R920.61	2.4851	A-601	N06601	-	-	0.04	23	59	-	-	Al
A	Alloy 600	R930.60	2.4816	A-600	N06600	-	-	0.06	16.3	74.5	-	-	-

Grade families: F = ferritic, A = austenitic, D = duplex *Max

CORROSION

PRE (Pitting Resistance Equivalent) is a factor comparing properties of different chemistries with regards to pitting and crevice corrosion in corrosive environments. A higher value means better resistance. In the table above, PRE is shown for the grades we recommend for welding.

SURFACES

- Direct cooling (DK) ASTM 10-13
- "In line"-annealing (DST) ASTM 5-8
- Pit furnace (SG) ASTM 3-6

Our standard procedure is to supply the wire rod in pickled condition.

DIMENSIONS

Standard: 5 – 18 mm (.197" - .709") in increments of 0.5 mm (.020")
(MOQ:s for some dimensions)

Tolerance: 5.0 – 10.0 +/-0.15
>10.0 – 18.0 +/-0.20

Ovality: max 60% of the total tolerance span

PACKAGING METHODS

Coil weight: appr. 1000 kg - **Outer diameter**: max 1250 mm - **Inner diameter**: max 950 mm

MM-SP_April 2026_EN

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