

308 H Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Stainless steel Tig welding wire with high carbon content

APPLICATIONS Welding stainless steel types with an alloy content between 16 to 21% Cr and 8 to 13 % Ni, with high carbon content.

PROPERTIES Higher temperature and scale resistance than standard (L) types.

CLASSIFICATION

AWS	A 5.9: ER 308 / 308H
EN ISO	14343-A: W 19 9 H
DIN: W.Nr.	1.4948
DIN	8556: SG 12CrNi 19 9

SUITABLE FOR

UNS S30409	AISI :304H	W.Nr : 1.4948
UNS S32109	AISI :321H	W.Nr : 1.4941
UNS S34709	AISI :347H	W.Nr : 1.4961
-	-	W.Nr : 1.4948
-	-	W.Nr : 1.4850
X6CrNiNb 18-10, 18-11, X12CrNiTi 18-9		

APPROVALS CE approved

WELDING POSITIONS:



ALL-WELD METAL ANALYSES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.04-0.08	19.5-22.0	9.0-11.0	<0.50	1.0-2.5	0.3-0.65	<0.03	<0.03	<0.75

MECHANICAL PROPERTIES

Heat treatment	R _{P0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				+20C	-40° C	-60C	
AW	>420	>620	35	>100			

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing (kg)	
	Current (A) DC-		single	master
1.6 x 1000	50-80		5	25
2.4 x 1000	110-180		5	25

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1