

308H

CATEGORY GMAW-GTAW Solid wires

TYPE Solid stainless steel filler metal with high carbon content for high temperature applications.

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: G 19 9 H 14343-B: SS19-10H |
| 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 | 0.30-0.65 | <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 | >400 | >600 | 35 | 80 | | | |

WELDING PARAMETERS / PACKING

| Welding Parameters | | | Packing | | |
|--------------------|-------------|-----------------|------------|------------|-------------|
| D (mm) | Voltage (V) | Current (A) DC+ | spool type | kg / spool | kg / pallet |
| 1.0 | 15-28 | 80-240 | K-300 | 15 | 1080 |
| 1.2 | 15-29 | 100-300 | K-300 | 15 | 1080 |

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M11, M12, M13