

Applications

TIG welding of 18%-8%Ni stainless steel.

Characteristics on Usage

ST-308 is a filler rod for TIG welding with pure Ar gas.

As the weld metal contains ferrite, its crack resistibility is excellent.

Both its bead appearance and weldability are good.

Furthermore, resistance to corrosion and mechanical properties is good.

Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Ni
0.05	0.38	1.75	19.8	10.1

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	CVN-Impact Value J(ft.lbs) 0°C (32°F)
610 (88,500)	40	130 (95)

Typical Welding Conditions (DC-)

Size mm(in)	Currents A	Gas Flow (ℓ /min.)	Shielding gas
1.2 (.045) ~ 2.0 (5/64)	50 ~ 100	25	Ar
1.6 (1/16) ~ 3.2 (1/8)	100 ~ 200		
2.4 (3/32) ~ 3.2 (1/8)	200 ~ 300		
3.2 (1/8)	300 ~ 400		

Approval

KR, ABS, DNV