

## Filler rod and wire

<b>Features:</b>	▪ Suitable for 18%Cr-8%Ni steel
<b>Classification:</b>	AWS A5.9 ER308
<b>Shielding gas:</b>	Ar
<b>Identification color:</b>	1st Yellow
<b>Polarity:</b>	DCEN

## Packaging data

φ mm	Spool	Tube		
	kg	kg	Length mm	g/piece
0.8	-	5	1,000	4
1.0	-	5	1,000	6
1.2	10	5	1,000	9
1.6	10	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
3.2	-	5	1,000	64
<b>Volume mm</b>	240W, 110H, 240L	40W, 35H, 1015L		

## Composition (rod and wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.05	0.08
<b>Si</b>	0.38	0.30~0.65
<b>Mn</b>	1.5	1.0~2.5
<b>P</b>	0.02	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	9.5	9.0~11.0
<b>Cr</b>	19.9	19.5~22.0
<b>Mo</b>	0.11	0.75
<b>Cu</b>	0.12	0.75

Note: <sup>a</sup> Single values are maximum.

## Welding parameters

φ mm	Current A
0.8	50~80
1.0	50~80
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

## All-weld mechanical properties

	Typical
<b>0.2%YS (MPa)</b>	410
<b>TS (MPa)</b>	580
<b>EI on 4d (%)</b>	42
<b>IV 0°C (J)</b>	150

## Approvals

<b>ABS</b>	AWS A5.9 ER308, MG
<b>DNV</b>	NV308
<b>NK</b>	KY308