

308H 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 Current (A) DC-	Packing (kg)	
		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