

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