



GMAW / GTAW STAINLESS STEEL
TIGINOX 308H

308H TYPE STAINLESS STEEL TIG ROD



CLASSIFICATION : AWS A/SFA 5.9

APPROVALS :

ER308H

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KEY FEATURES :

- 308H type SS TIG rod
- High carbon than conventional 308 grade wire
- Higher strength at elevated temperature
- Radiographic quality welds

WELDING POSITION :



GMAW: DCEP

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

TYPICAL APPLICATIONS :

- Welding of 304H type materials
- Chemical, petrochemical industries
- Distillery, dairy, restaurant equipment
- For high temperature applications

STORAGE / HANDLING :

Keep dry during storage and handling

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.04-0.08	1.0-2.5	0.30-0.65	19.5-22.0	9.0-11.0	0.50 max	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	550 min	35 min

Mechanical properties will vary with the type of shielding gas used.

PACKING DATA :

Ø, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
1.6 x 1000	5	4	20
2.0 x 1000	5	4	20
2.5 x 1000	5	4	20
3.15/3.2 x 1000	5	4	20