308S96

MIG (GMAW)

SOLID WIRE FOR 304H STAINLESS STEEL

PRODUCT DESCRIPTION

Solid wire for MIG welding of 304H stainless steel

CLASSIFICATIONS

AWS A5.9M	ER308H
ISO 14343-A	19 9 H
ISO 14343-B	SS308H

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
min.	0.04	1.0	0.30	--	--	19.5	9.0	--	--
max.	0.08	2.0	0.65	0.020	0.030	20.5	10.0	0.25	0.25
Typical	0.05	1.8	0.4	0.002	0.015	19.9	9.5	0.1	0.1

Typical ferrite level of undiluted weld metal is in the range 3-8FN.
ER19-10H (on request) has Cr ≤ 20.0, Mo ≤ 0.25, Nb ≤ 0.05, Ti ≤ 0.05.

ALL-WELD MECHANICAL PROPERTIES

Typical values as welded

Tensile strength (MPa)	630
0.2% proof strength (MPa)	450
Elongation (%) 4d	43
Impact ISO-V(J) +20°C	> 100
Hardness (HV)	195/215

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Voltage
Ar/2%O_2 or Ar/1-3%CO_2	260A, DC+	1.2	28V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
0.8	12.5	S300	M308S96-08
0.9	15	S300	M308S96-09
1.0	15	S300	M308S96-10
1.2	15	S100	M308S96-12

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr^3	Ni	Mo	Cu	OES (mg/m³)
32	12	16	8	<0.5	<0.5	3.1