

308S96

TIG (GTAW)

SOLID WIRE FOR 304H STAINLESS STEEL

PRODUCT DESCRIPTION

Solid wire for TIG 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 $\leq$ 20.0, Mo $\leq$ 0.25, Nb $\leq$ 0.05, Ti $\leq$ 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
Argon	100A, DC-	2.4	12V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	2.5	PE TUBE	T308S96-16
2.0	2.5	PE TUBE	T308S96-20
2.4	2.5	PE TUBE	T308S96-24
3.2	2.5	PE TUBE	T308S96-32

HIGH TEMPERATURE ALLOYS