

308S96

SAW

SOLID WIRE FOR 304H STAINLESS STEEL

PRODUCT DESCRIPTION

Solid wire for subarc 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

As welded	Typical
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

Flux	Current	Diameter (mm)	Voltage
P2007 or SSB flux	350A, DC+	2.4	30V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
3.2	25	B415	SA308S96-32

HIGH TEMPERATURE ALLOYS