

**MIG / TIG 308H**

MIG/TIG 308H consumables are designed to match unstabilised 18Cr-10Ni austenitic stainless steels for elevated temperature strength and oxidation resistance. These steels and the weld metal have carbon content controlled to 0.04-0.08%. The 308H consumables should also be considered for welding thick



(> 12mm) stabilised grades 321H or 347H to avoid in-service HAZ cracking and low creep rupture ductility associated with 347 weld metal.

**MATERIALS TO BE WELDED**

ASTM / UNS 304 H, S30409, CF 10, CF 8  
 DIN 1-4948  
 BS 304S51, 302C25, 304C15

**CLASSIFICATIONS**

	TIG/MIG	
AWS	A5.9	ER308H
BS EN	12072	19 9 H
DIN	8556	SG X5CrNi 19 9 (1.4302)

**CHEMICAL ANALYSIS**

% Carbon	0.050	% Chromium	19.90
% Manganese	1.800	% Nickel	9.500
% Silicon	0.400	% Molybdenum	0.100
% Sulphur	0.002	% Copper	0.100
% Phosphorus	0.015		

**TYPICAL MECHANICAL PROPERTIES  
ALL WELD METAL**

	TIG
Tensile Strength	630 MPa
0.2% Proof Stress	450 MPa
Elongation on 4d	43%
Impact Energy 20°C	> 100J

**Microstructure**  
 Austenite with delta ferrite controlled 3-8FN.

**PACKING DATA**

**MIG (DC+)**

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.20	260	28	033-026	15

**TIG (DC-)**

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.60	100	12	030-417	5
2.00	100	12	030-418	5
2.40	100	12	030-419	5

Suggested gas for welding: *Stainshield Plus, Stainshield (MIG), Argon (TIG)*

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