

SUPERCORE 308HP



Supercore 308HP is 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. Note that some authorities recommend the use of type 16-8-2 types for these steels, including 304H.

CLASSIFICATIONS

AWS A5.22 E308HT1-4

CHEMICAL ANALYSIS

% Carbon	0.050	% Chromium	18.80
% Manganese	1.300	% Nickel	9.500
% Silicon	0.500	% Molybdenum	0.100
% Sulphur	0.010	% Copper	0.100
% Phosphorous	0.020	% Ferrite	5

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	620 MPa
0.2% Proof Stress	420 MPa
Elongation on 4d	40%
Impact Energy 20°C	100 J

Microstructure
Austenite with delta ferrite controlled 2-8FN.

PACKING DATA

(DC+)

Diameter (mm)	Current (A)		Stickout (mm)	Item Number	Pack Mass (Kg)
	Amps	Volts			
1.20	140 - 250	23 - 32	12 - 20	081-103	15

Suggested gas for FCW welding: Fluxshield

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