TIGWELD 308H

TIG Rods [GTAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : W 19 9 H DIN 8556 : SG-X5 CrNi19 9 AWS A-5.9 : ER 308H W.Nr. : 1.4302		Petrochemical and chemical industry

- Welding wire for welding similar stainless steel, corrosion-resistant, with increased carbon content.
- Scale resistant in high temperature.
- Operating temperature up to [700°C].

Application

- Used in the chemical and petrochemical industries for welding pipes and boilers.
- Equipment for distilleries, dairies, restaurants
- For high temperature applications.

Base material

AISI/ASTM	EN 10088-1/2	W.Nr.
304H	X6 CrNi18 11	1.4948
321H	X8CrNiTi18 10	1.4941
347H	X8CrNiNb16 13	1.4961
		1.4850
	X6CrNiNb18 10	
	X12CrNiTi18 9	

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	Cu	P	S
0,04-0,08	0,65	1,0-2,5	19,5-22,0	9,0-11,0	0,50	0,75	0,03	0,03

Typical mechanical properties

Yield strength Re [N/mm2]	>350
Tensile strength Rm [N/mm2]	>550
Elongation A5 [%]	>30
Impact energy Kv [J]	>47 J (20°C) /
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	I1 - Ar / I3 - Ar + >0-95% He /

Welding parameters and packing

⌀	Length [mm]	Weight of packet [kg]

1,6	1000 /	5,0
2,0	1000 /	5,0
2,4	1000 /	5,0
3,2	1000 /	5,0

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