

## 308H

### Comparable specifications

**ASME SFA A 5.9:** ER308/308H  
**EN ISO 14343-A:** 19 9 H  
**Werkstoff Nr.:** 1.4302

### Description and applications\*

\* *Illustrative, not-exhaustive list*

Austenitic stainless steel filler metal with the same chemical composition as 308L, except that the allowable carbon content has been restricted to the higher portion of the 308 range.

Carbon content in the range of 0.04%-0.08% provides higher tensile and creep strengths at elevated temperatures; it is used for service temperature up to +700°C.

Specially designed for welding 304H base metal.

This grade may be used for:

- welding type 304H material and other similar materials as below listed;
- applications where hot cracking resistance is expected;
- applications in chemical and petrochemical industries;
- applications in distillery, dairy and restaurant equipment productions;
- applications in pulp and paper industry.

### Weldable base materials\*

\* *Illustrative, not-exhaustive list*

Austenitic stainless steels such as 301, 302, 304, 304H and 305.

### All-weld metal mech. properties\*

\* *For reference only values*

**Tensile strength (Rm):**  $\geq 550 \text{ N/mm}^2$     **Yield Strength (Rp<sub>0.2</sub>):**  $\geq 350 \text{ N/mm}^2$   
**Elongation:**  $\geq 30\%$

### Chemical composition\*

\* *For reference only values*

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.04	1.00	0.30	max	max	9.00	19.50	max	max
0.08	2.50	0.65	0.020	0.030	11.00	21.00	0.50	0.50

### Standard packaging data\*

Welding process	Product type	Ø mm (inches)	Packing type	Weight kg (lbs)	Length mm (inches)
GMAW **	filler wire	0.80 - 1.20 (0.030 - 0.047)	spools BS300 / D300	15 (33)	n.a.
GTAW **	filler rod	1.60 - 4.00 (1/16 - 5/32)	cardboard boxes / tubes	5 (11)	1000 (39.4)
SAW **	filler wire	1.60 - 4.00 (1/16 - 5/32)	basket rims B450	25 (55)	n.a.

\* *Other sizes and packing types are available upon request*

\*\* *GMAW: gas metal arc welding; GTAW: gas tungsten arc welding; SAW: submerged arc welding*

### Marking

Each filler rod for GTAW welding is durably marked with an identification traceable to the unique product type. Welding filler materials wound on spools or in coils are durably marked on the coil or spool with an identification traceable to the unique product type.

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

Customized labels are available upon request.

### Type approvals

**Canadian Welding Bureau** Cert. nr. NOV308H (GMAW / GTAW)

### Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.