Inweld 308H

AWS A5.9 ER308H

Chemical Composition of Inweld 308H

C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu	Fe
0.04-0.08	19.5-22.0	9.0-11.0	0.50	1.0-2.5	0.30-0.65	0.03	0.03	---	0.75	Balance

Single values are maximum unless otherwise specified.

Description and Applications

This classification is the same as ER308, 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 strength at elevated temperatures. This filler metal is used for welding 304H base metal.

Procedure

Typical Weld Metal Properties

	AWS Spec (ksi)
Average As-Welded Hardness:	
Tensile Strength:	80,000
Yield Strength:	
Elongation:	35%

Recommended Parameters

Wire Diameter	Voltage	Amperage