

MIGWELD 308H

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

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

- Wire for welding single-grade stainless steels, resistant to corrosion, with increased carbon content.
- Increased resistance to high temperatures and scaling.
- Working temperature up to 700[°C].
- Largely resistant to the formation of intermetallic phases.

Application

Przemysł petrochemiczny, energetyczny i nuklearny.

Base material

DIN	W.Nr.	AISI/ASME
X5 CrNi18 10	1.4301	304H
G-X6 CrNi18 9	1.4308	CF-8
X6 CrNi18 11	1.4948	304H
X4 CrNi18 10	1.4301	304
G-X5 CrNi19 10	1.4308	CF-8

Typical chemical composition %

C	Si	Mn	Cr	Ni
0,04-0,08	0,30-0,65	1,00-2,50	19,50-21,00	9,00-11,00

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) /
Wire/rod type	solid
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	I1 - Ar / M12 - Ar + 0.5 - 5% CO2 / M13 - Ar + 0.5 - 3% O2 /

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	100-160	18-22	15,0

1,0	140-200	18-24	15,0
1,2	170-260	20-28	15,0

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