STAINLESS STEEL BARE WIRE DATA SHEET

executive 308H

DESCRIPTION

Executive 308H is used for welding of unstabilized stainless steels such as types 301, 302, 304, 305 and 308. The filler metal is the most popular grade among stainless steels, used for general purpose applications where corrosion conditions are moderate. ER308H is the same classification 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 provide higher strength at elevated temperatures. This filler metal is used for welding 304H base metal. Heats are selected to have ferrites between 3-8 WRC-92 and have controlled limits of antimony, bismuth & boron.

TYPICAL CHEMISTRY RANGE

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.05	20.0	10.0	0.1	1.7	0.4	0.02	0.02	0.75

WELDING PARAMETERS

Process	Size	Volts	Amps	Speed of Welding / Gas Flow	Shielding Gas / Flux
SAW	.093	29 - 32	300 - 350	20 - 30 IPM (500 to 750mm)/min	Record IN Flux
	.125	29 - 32	400 - 550	20 - 30 IPM (500 to 750mm)/min	Record IN Flux
	.156	29 - 32	500 - 650	20 - 30 IPM (500 to 750mm)/min	Record IN Flux
GMAW	.035	29 - 33	160 - 180	30 to 50 CFH	98/99% Ar + 2/1% O_2
	.045	29 - 33	180 - 220	30 to 50 CFH	or
	.062	29 - 33	210 - 250	30 to 50 CFH	97% Ar + 3% CO_2
GTAW	.093	Direct Current; Electrode –		30 to 40 CFH	100% Ar

MECHANICAL PROPERTIES

Tensile Strength:	88,500 PSI minimum	610 MPA
Yield Strength:	59,500 PSI	410 MPA
Elongation:	39%	

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to AWS/SFA 5.9, Class **ER308H** and is certified by the Canadian Welding Bureau to AWS A5.9. ISO 14343A, Class E19 9 H and ISO 14343B, Class ES308H.