

## RAAJMIG ER 308H

### Stainless steel continuous & cut length solid welding wire for MIG/TIG welding

**CLASSIFICATION** : AWS/SFA-5.9: ER308H

**CHARACTERISTICS** : ER308H is Stainless steel welding wire with restricted carbon content 0.04 % to 0.08 % designed to weld corresponding to 301, 302, 304H type. ER 308H provide a high carbon deposit for high temperature application. The weld bead is smooth, even and shiny.

**TYPICAL APPLICATION:**

- Used to weld un-stabilized austenitic stainless steels such as 301, 302, 304H
- Chemical & Petro chemical industries. Pulp and Paper industries
- Used for their high tensile strength e.g. in agricultural implements, automobile industries, Construction segment, etc.

**SHIELDING GAS** : welding with 100% Ar gas Or Ar+2%O<sub>2</sub> gas.

**CHEMICAL COMPOSITION % (solid wire chemistry)**

C	Mn	Si	S	P	Ni
0.04 – 0.08	1.00 – 2.50	0.30 - 0.65	0.030 Max	0.030 Max	9.00 -11.00
Cr	Mo	Cu			
19.50 - 22.00	0.75 max.	0.75 Max			

**TYPICAL ALL WELD MECHANICAL PROPERTIES (UNDER Ar GAS SHIELD)**

UTS (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation %	CVN IMPACT
570	430	35	+20 <sup>0</sup> C : 100-150 J

**DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIG ER308H)**

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg	Drum packing 100/250kg
0.80	0.031	70-220	16-24	10-20	√	√	X
1.20	0.047	150-300	24-34	15-25	√	√	√
1.60	0.062	150-350	28-36	15-30	√	√	√

**DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIG ER308H)**

Size (mm)	Size (inch)	Length (mm)	Length (inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/16"	1000	36"	40-80	10-16	√	√
2.0	5/64"	1000	36"	50-100	12-18	√	√
2.4/ 2.5	3/32"	1000	36"	60-120	14-20	√	√
3.2	1/8"	1000	36"	100-150	16-24	√	√
4.0	5/32"	1000	36"	140-200	18-28	√	√

**Raajratna** offer a wide range of Stainless steel welding wires for MIG/TIG/SA welding. Tailor made packing available on request