



Techalloy 308/308H

Description

Techalloy 308/308H is used for TIG, MIG, and submerged arc welding of 304 and 304H stainless steels. The higher carbon content gives higher strength at elevated temperatures with some sacrifice in corrosion resistance.

Specifications & Approvals

AWS A5.9 ER308/308H

UNS S30880

CWB

Typical Chemical Composition

C	Mn	Si	Cr	Mo	Ni	Nb	N	S	P	Cu	FN (WRC)
.05	1.65	.46	20.45		9.85			.005	.016		8

Typical Mechanical Properties

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

Welding Parameters

	Shielding	Gas Flow	Diameter	Voltage	Amperage
Mig Welding	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO2	30 to 50 CFH	.035" (0.9mm) .045" (1.14mm) .062" (1.6mm))	26 to 29 28 TO 32 29 TO 33	160/210 180/250 200/280
Tig Welding					
SubArc Welding	Suitable flux may be used		3/32" (2.5mm) 1/8" (3.14mm) 5/32" (4.0mm)	28 to 33 29 TO 32 30 TO 33	275/350 350/450 400/550

Standard Packages:

Mig Wire– 33# wire basket	Tig Wire– 10# tube/30# Master Carton	SAW– 60# Coil
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