KFW-308H

Shielding gas: CO_2 or Ar+20%CO_2

Classification

AWS	E308HT1-1/4	—
JIS	Z3323	TS308H-BiF-FB0
EN	17633-A	T Z 19 9 H P M 1
GB	—	—

Applications and Features

(1) Weld metal is austenite with 20% Cr-10% Ni.

(2) It provides good strength at high temperature due to higher carbon content.

(3) It is suitable for welding AISI 304 and 308H steel.

Welding Instruction

(1) Use Ar blend with 1~2%O_2 for high current, spray transfer welding.

(2) Use Ar blend with 1~2%CO_2 for low current, short-circuit transfer welding.

(3) For other instructions, please refer to Appendix D.

(4) For extra information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : Ar+2%O_2)

C	Si	Mn	P	S	Cr	Ni
0.06	0.40	1.36	0.02	0.02	19.56	10.23

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2%O_2)

Tensile Strength N/mm^2 (kgf/mm^2)	Yield Strength N/mm^2 (kgf/mm^2)	Elongation %
560	370	45

Size and Suggested Operating Range (DC+)

Operating range \ Diameter (mm)		0.8	0.9	1.0	1.2	1.4	1.6
Ar+1~2%CO_2	Amp	—	60~140	80~160	100~210	—	—
	Volt	—	15~21	16~22	17~22	—	—
Ar+1~2%O_2	Amp	—	170~260	180~280	200~300	210~320	220~330
	Volt	—	24~30	24~30	24~30	24~32	24~32