

# GETIG 308H



SPECIFICATIONS :AWS/SFA 5.9 ER308H BS2901-93 308S98 DIN 8556-86 SGX5CrNi 199 prEN 12072-95 W19.9H

## CHARACTERISTICS :

Getig 308H deposits a 20% Cr / 10% Ni austenitic stainless weld metal with controlled carbon content (0.04 % - 0.08 %). It is designed to weld similar composition stainless steels used for their creep strength and oxidation resistance at temperatures upto 800° C.

## APPLICATIONS :

For welding ASTM A304/A304H steel, 321H and 347H stainless steels CF10, CF8. Widely used in petrochemical industry for fabrication of cyclones, transfer lines in catalytic crackers operating in the range 450 – 815°C.

**SHIELDING GAS :** Pure Argon 99.99% 6-12 l/min.

**FERRITE CONTENT IN THE WELD METAL :** 3 – 9 FN.

**WELDING CURRENT :** DC ( - )

**CORROSION RESISTANCE :** Good resistance to general and intergranular corrosion. Also good resistance to oxidising acids and cold reducing acids.

## COMPOSITION OF THE WIRE (RANGE) % :

C	Mn	Si	Cr	Cu	Ni	Mo	S	P
0.04 - 0.08	1.0- 2.50	0.30-0.65	19.5 - 22	0.50 max	9 - 11	0.50 max	0.025 max	0.03 max

## MECHANICAL PROPERTIES (RANGE):

Tensile Strength	Elongation (%) (L=4D)	Charpy V-notch impact value in joules
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550 - 650

35 - 45

0°C

60 - 100

## RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	PACKING PER BOX
1.6	1000	5Kg
2.0	1000	5Kg
2.5	1000	5Kg
3.15	1000	5Kg
4.0	1000	5Kg