



# WB308HM MIG WELDING WIRE

<b>Classifications</b>	<b>AWS A5.9:</b> ER308H <b>BS EN ISO 14343-A:</b> G 19 9 H																													
<b>Product Description</b>	308H stainless steel, solid MIG wire.																													
<b>Applications</b>	<p>WB308HT is suitable for the repair and welding of wrought and cast alloys such as 304S51 and 302C25. Suitable for use in corrosive environments up to 800°C.</p> <p>Also suitable for welding type 321H stabilised grades.</p> <p>Typical applications :- food, pressure vessels, valves and general stainless steel engineering.</p> <p>Ferrite in the 3-8 FN range.</p>																													
<b>Wire Composition (Wt. %)</b>		C	Mn	Si	S	P	Cr	Ni	Mo	Cu																				
<b>min.</b>		0.04	1.0	0.30	-	-	19.5	9.0	-	-																				
<b>max.</b>		0.08	2.5	0.65	0.03	0.03	22.0	11.0	0.5	0.50																				
<b>Typical All-Weld Metal Mechanical Properties</b>		<table border="0"> <tr> <td>Ultimate Tensile Strength</td> <td>N/mm<sup>2</sup></td> <td>Typical</td> <td>590</td> </tr> <tr> <td>Yield Stress/0.2% Proof Stress</td> <td>N/mm<sup>2</sup></td> <td></td> <td>395</td> </tr> <tr> <td>Elongation on 5D</td> <td>%</td> <td></td> <td>40</td> </tr> <tr> <td>Impact Energy CV @ +20°C</td> <td>Joules</td> <td></td> <td>75</td> </tr> <tr> <td>As welded</td> <td></td> <td></td> <td></td> </tr> </table>									Ultimate Tensile Strength	N/mm <sup>2</sup>	Typical	590	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>		395	Elongation on 5D	%		40	Impact Energy CV @ +20°C	Joules		75	As welded			
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<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	100	100	200	-	-
	<b>max.</b>	-	-	200	280	380	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	14	15	22	-	-
	<b>max.</b>	-	-	22	28	32	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	-	-	-	-	-

<b>Storage</b>	<p><b>Storage</b></p> <p>It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.</p>
<b>Gases</b>	<p><b>Gas</b></p> <p>Argon + 2%O<sub>2</sub> or Argon + 2-3%CO<sub>2</sub></p> <p><b>Flow Rate</b></p> <p>15-20 L/min</p>

### Current Conditions DC+ and Welding Positions

