



WB308HT TIG WELDING WIRE

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|---|---|------|-------------------|------|------|----------|------|------|-----|------|
| Classifications | AWS A5.9: ER308H BS EN ISO 14343-A: W 19 9 H | | | | | | | | | |
| Product Description | 308H stainless steel, solid TIG wire. | | | | | | | | | |
| Applications | <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. 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> | | | | | | | | | |
| Wire Composition (Wt. %) | | C | Mn | Si | S | P | Cr | Ni | Mo | Cu |
| min. | | 0.04 | 1.0 | 0.30 | - | - | 19.5 | 9.0 | - | - |
| max. | | 0.08 | 2.5 | 0.65 | 0.03 | 0.03 | 22.0 | 11.0 | 0.5 | 0.50 |
| Typical All-Weld Metal Mechanical Properties | Ultimate Tensile Strength | | N/mm ² | | | 510 min. | | | | |
| | Yield Stress/0.2% Proof Stress | | N/mm ² | | | 320 min. | | | | |
| | Elongation on 5D | | % | | | 30 min. | | | | |
| | Impact Energy CV @ | | Joules | | | - | | | | |
| | As welded | | | | | | | | | |

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|------------------------------|---|-------|-------|-------|-------|-------|-------|-------|
| Wire Dia. (mm) | | 0.6mm | 0.8mm | 1.0mm | 1.2mm | 1.6mm | 2.4mm | 3.2mm |
| Current Range (Amps) | min. | - | - | - | - | 60 | 80 | 100 |
| | max. | - | - | - | - | 100 | 140 | 180 |
| Volt Range (Volts) | min. | - | - | - | - | - | - | - |
| | max. | - | - | - | - | - | - | - |
| Packaging Information | | | | | | | | |
| Kg Per Tube | | - | - | - | - | 5 | 5 | 5 |
| Storage | Storage 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%. | | | | | | | |
| Gases | Gas Pure Argon Flow Rate 12-14 L/min | | | | | | | |

Current Conditions DC- and Welding Positions

