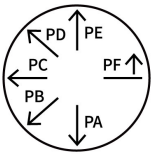


SW-308HBF

Classification

AWS AWS A5.22/ ASME SFA-5.22 E308HT1-1/-4
JIS Z 3323 TS308H-BiF-FB1
EN ISO 17633-B T 308H F M21/C1 2

Welding Positions



Features

- Designed for welding with 100% CO2 or Ar+15~25% CO2 shielding gas
- Excellent all position weldability
- Smooth and stable arc with a fast freezing slag

Polarity

DC+

Application Areas

- Welding of 18%Cr-8%Ni stainless steels for high temperature service

Shielding Gas

100% CO2
Ar+15~25% CO2

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	Bi
100% CO2	0.05	0.6	1.0	0.014	0.009	0.01	10.2	18.5	0.01	≤ 10ppm
Ar+20% CO2	0.05	0.6	1.0	0.019	0.008	0.01	10.2	19.1	0.01	≤ 10ppm

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	580 (84)	41	-20 (0) -60 (-75)	59 (44) 52 (38)
Ar + 20% CO2	585 (85)	42	-20 (0) -60 (-75)	62 (46) 53 (39)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	140~180	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux