Unibraze 308-16/308H-16

CLASSIFICATIONS: AWS A5.4/ASME SFA 5.4 Class E308-16/E308H-16 UNS W30810

DESCRIPTION: Unibraze 308-16/ 308H-16 is an all position stainless steel electrode that is the same as E308-16 except the carbon content is restricted to .04 minimum. The carbon restriction provides higher tensile and creep strengths at elevated temperatures. **Unibraze 308-16/308H-16** is suitable for welding 304H. Weld metal ferrite is targeted to 5 FN to minimize the effect of sigma embrittlement in high- temperature service.

Typical Chemistry:

	C	Cr	Ni	Mo	Mn	Si	P	S	Cu	FN (WRC)
AWS/ ASME	.04-.08	18.0-21.0	9.0-11.0	.75 max	.5-2.5	1.0 max	.04 max	.03 max	.75 max	Not Required
Typical (As welded)	.044	19.05	10.03	.061	.67	.81	.022	.018	.096	2-4

Typical Mechanical Properties:

	AWS/ASME	Typical
Tensile Strength	80,000 psi (550 MPa) min.	89,198 psi (615 MPa)
Yield Strength	Not required	-
Elongation	35% min.	45%

Typical Welding Parameters: (DCEP or AC)

Dia.	Amps Flat	Amps Out of Position	Voltage
3/32”	70-90	65-80	20-23
1/8”	80-110	75-95	21-24
5/32”	110-160	100-120	22-25
3/16”	120-190	110-130	23-26