Unibraze 308/308H

CLASSIFICATIONS: AWS A5.9/ASME SFA 5.9 Class ER308/ER308H UNS S30880

DESCRIPTION:
Unibraze 308/308H is used for TIG, MIG, and submerged arc welding of 304 and 304H stainless steels. The higher carbon content gives higher strength at elevated temperatures, but with some sacrifice in corrosion resistance.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu	FN
.04-.08	19.5-22.0	9.0-11.0	.50 max	1.0-2.5	.30-.65	.03 max	.03 max		.75 max	8 (WRC)

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	88,500 psi (610MPa)
Yield Strength	59,500 psi (410 MPa)
Elongation	39%
Charpy Impacts@-320ºF	45 ft lbs

TYPICAL WELDING PARAMETERS:

	Shielding Gas	Gas Flow	Diameter	Voltage	Amperage
MIG	98/99% Ar +2/1% O 97%Ar + 3% CO_2	30 to 50 CFH	.035" (.9mm) .045" (1.14mm) .062" (1.6mm)	26-29 28-32 29-33	160 /210 180/250 200/280
TIG	100% Ar		1/16" (1.6mm) 3/32" (2.4mm) 1/8" (3.2mm)	14-18 15-20 15-20	90/130 120/175 150/220
SUBARC	Suitable Flux		3/32" (2.4mm) 1/8" (3.2mm)	28-33 29-32	275/350 350/450