

Shield-Bright 308H

FCAW wire for 18%Cr - 8%Ni stainless steel, For all-position welding. Shield-Bright 308H was developed for welding Type 304H stainless steel and can also be used for welding Type 301, 302, and 304 steels. It contains a higher carbon level than 308L filler metals to give greater high temperature strength. The ferrite content is also lower for high temperature service. It has greater ductility than 347 types at high temperatures and for that reason it is sometimes used to weld Types 321 and 347 for service above 750°F(399°C) coupled with high stress. Shield-Bright 308H was designed for welding in all positions and performs particularly well in the vertical position with excellent slag removal.

Tekniset tiedot	
Luokitukset	SFA/AWS A5.22 : E308HT1-1 SFA/AWS A5.22 : E308HT1-4 JIS Z 3323 : YF 308C KS D 3612 : YF 308C EN ISO 17633-A : T 19 9 H P C1 2 EN ISO 17633-A : T 19 9 H P M21 2 JIS Z 3232 : TS308H-FB1
Ala	Teollinen tuotanto Petrokemia Voimalat

Hitsausvirta	DC+
Seostyyppi	C Cr Ni
Suojakaasu	M21, C1 (EN ISO 14175)

Tyypilliset lujuusarvot			
Tila	Myötöraja	Murtolujuus	Venymä
M21 Shielding Gas			
Hitsatussa tilassa	430 MPa	600 MPa	42 %
C1 Shielding Gas			
Hitsatussa tilassa	392 MPa	578 MPa	44 %

Charpy V -iskusitkeys		
Tila	Testauslämpötila	Iskusitkeys
M21 Shielding Gas		
Hitsatussa tilassa	-29 °C	50 J
Hitsatussa tilassa	-196 °C	28 J
C1 Shielding Gas		
Hitsatussa tilassa	-196 °C	26 J
Hitsatussa tilassa	-29 °C	47 J

Hitsiaineen Koostumus						
C	Mn	Si	S	P	Ni	Cr
M21 Shielding Gas						
0.060	1.20	0.90	0.007	0.020	9.8	19.5
C1 Shielding Gas						
0.050	1.10	0.80	0.007	0.020	9.5	19.3

Hitsausarvot				
Halkaisija	A	Jännite	Langansyöttönopeus	Hitsiaineentuotto
1.2 mm	130-220 A	24-29 V	5.8-14.4 m/min	1.9-4.6 kg/h