

## MIG/MAG solid wires-TIG rods Stainless and Heat resistant steels

INERTFIL 308H is a G 19 9 H/ER308H type solid MAG welding wire, supplied precision layer wound, depositing a C-19Cr9Ni weld metal. Suitable for use with Ar+2%O<sub>2</sub> or Ar+0.5...5%CO<sub>2</sub> mixed shielding gases.

INERTFIL 308H is suitable for welding AISI 304H austenitic stainless steel and similar steels. It is used mainly in petrochemical industry including the fabrication of pipe and vessel.

The higher carbon content results in higher strength at elevated temperatures.

### Classification

EN ISO	14343-A: G 19 9 H
AWS	A5.9: ER 308H

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni
0.060	1.9	0.5	≤ 0.020	≤ 0.020	20.0	10.0

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-10 °C
As Welded	≥350	≥550	≥35	≥70	≥32

Gas test: 98% Ar+2% O<sub>2</sub>

**Shielding Gas** - EN ISO 14175 : M12, M13

### Materials

AISI 304H; 1.4948 (X6CrNi18-10); 1.4310 (X10CrNi18-8)

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



### Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
1.0	●
1.2	●