

**MIDALLOY ER308/308H BARE WIRE**

**CLASSIFICATION**

- AWS 5.9 Class ER308/ER308H / ASME SFA 5.9 Class ER308/ER308H
- UNS# S30880 A#8 F#6

**DESCRIPTION**

- MIDALLOY ER308/ER308H stainless steel wire is used for GMAW, GTAW and SAW welding.

**APPLICATIONS**

- MIDALLOY ER308/ER308H is used for joining similar alloys such as 18-8, 19-9, and 20-10. It is used extensively for joining type 304 and type 304H materials.
- MIDALLOY ER308/ER308H can be used for mig, tig, and sub-arc welding. Carbon content in the range of .04-.08% provides higher strength at elevated temperatures.

**TYPICAL CHEMISTRY**

C	Si	Cr	Mn	P	Cu	S	N	Mo	Ni
.05	.43	19.7	1.97	.015	.05	.010	.06	.15	9.19

**TYPICAL MECHANICAL PROPERTIES**

TENSILE STRENGTH	86,500 PSI
YIELD STRENGTH	57,500 PSI
ELONGATION IN 2"	39%

**RECOMMENDED WELDING PARAMETERS**

PROCESS	DIAMETER	VOLTAGE	AMPERAGE	GAS/FLUX*
TIG (GTAW)	1/16"	14-18	90-130	100% Ar
	3/32"	15-20	120-175	100% Ar
	1/8"	15-20	150-220	100% Ar
MIG (GMAW)	.035" SHORT ARC	16-26	70-160	69%Ar-30%He-1%O <sub>2</sub>
	.035" SPRAY ARC	26-31	150-230	92%Ar-8%Co <sub>2</sub> or
	.045" SPRAY ARC	28-32	180-280	98%Ar-2%O <sub>2</sub>
SUB ARC (SAW)	3/32"	28-30	275-350	Record IN or
	1/8"	29-32	350-450	Record IND 24

**PACKAGING**

- TIG 10 lb. tube/60 lb. carton
- MIG 30 lb. spool
- SUB-ARC 60 lb. coil

10/8/09

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