

**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

*The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.*

Office and Corporate Warehouse  
 630 Axminister Drive  
 St. Louis, MO 63026 • 636-349-6000 • 800-776-3300  
 Fax 636-349-2240

