

# GM 308

## IDENTIFICATION

GM 308, ER 308

## CLASSIFICATION

AWS/SFA 5.9 ER308

BS 2901-90 308 S92 DIN 8556-86 WSGX2 CrNi199

## DESCRIPTION

A solid, smooth wire primarily intended for welding the low carbon, 18% Cr, 10% Ni, type 304, austenitic stainless steels. Deposited weld metal has improved resistance to general corrosion. The deposited weld metal is of radiographic quality.

## CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Cu	Mo	S	P
0.080 max	1.0 - 2.5	0.30 - 0.65	19.50 - 22.0	9.0 - 11.0	0.50 max	0.50 max	0.025 max	0.030 max

## MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
550 min	30 min	20°C	100 - 140
		-100°C	40 - 80

## TYPICAL APPLICATIONS

- Suitable for welding normal carbon 304, 304L grades and Nb or Ti stabilized steels type 347 and 321 provided service temperatures are below 400°C.
- Widely used for chemical process plants.

## CORROSION RESISTANCE:

Good resistance to general and intergranular corrosion oxidizing acids. Good resistance to chlorise pitting corrosion.

**FERRITE** : Ferrite no. of undiluted weld metal is in the range 3 to 10.

**WELDING CURRENT** : DC (-)

**SHIELDING GAS** : Ar + 2 % O<sub>2</sub> , 16 - 21 l/min

## PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5
1	12.5

1.2	12.5
1.6	12.5