

# GM 308H

## IDENTIFICATION

GM 308H, ER 308H

## CLASSIFICATION

AWS/SFA 5.9: ER308H BS2901-93 308S98

DIN 8556-86 SGX5CrNi 199 prEN 12072-95 W19.9H

## DESCRIPTION

GM 308H deposits a 20% Cr / 10% Ni austenitic stainless weld metal with controlled carbon content (0.04% - 0.08 %). It is designed to weld similar composition stainless steels used for their creep strength and oxidation resistance at temperatures upto 800o C.

## CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Cu	Ni	Mo	S	P
0.04 - 0.08	1.0 - 2.50	0.30 - 0.65	19.5 - 22	0.50 max	09-Nov	0.50 max	0.025 max	0.03 max

## MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
550 - 650	35 - 45	0°C	60 - 100

## TYPICAL APPLICATIONS

- For welding ASTM A304/A304H steel, 321H and 347H stainless steels CF10, CF8.
- Widely used in petrochemical industry for fabrication of cyclones, transfer lines in catalytic crackers operating in the range 450-815oC.

**SHIELDING GAS :** Pure Argon 99.99% 6-12 l/min.

**FERRITE CONTENT IN THE WELD METAL:** 3-9 FN.

**WELDING CURRENT :** DC (-)

## CORROSION RESISTANCE

Good resistance to general and intergranular corrosion. Also good resistance to oxidising acids and cold reducing acids.

## PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5
1	12.5
1.2	12.5
1.6	12.5