

# KM-308H

## Classification

Shielding Gas:	Ar+1~2%O <sub>2</sub>	AWS A5.9/A5.9M	ER308H
	Ar+1~2%CO <sub>2</sub>	AS/NZS 14343	B SS308H

## Applications and Features

- ( 1 ) Weld metal is austenite structure with 20%Cr-10%Ni.
- ( 2 ) Good strength at high temperature due to higher carbon content.
- ( 3 ) It is suitable for welding AISI 304, 304H and 308H steel.

## Welding Instruction

- ( 1 ) Use Ar blend with 1~2%O<sub>2</sub> for high current spray transfer welding.
- ( 2 ) Use Ar blend with 1~2%CO<sub>2</sub> for low current, short-circuit transfer welding.

## Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Ni
0.061	0.38	1.82	0.013	0.011	19.64	10.03

## Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2%O<sub>2</sub>)

Tensile Strength MPa	Yield Strength MPa	Elongation %
600	440	42

## Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm)	
		0.9	1.2
Ar+1~2%CO <sub>2</sub>	Amp	60~140	100~210
	Volt	15~21	17~22
Ar+1~2%O <sub>2</sub>	Amp	170~260	200~300
	Volt	24~30	24~30

Diam.	15 kg Spool
0.9mm	KM308H09
1.2mm	KM308H12

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