

SW-308HBF

Type : Rutiles

Conformances

AWS A5.22/ ASME SFA5.22 E308HT1-1/-4

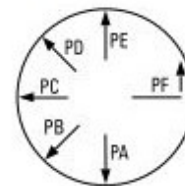
Applications

- Welding of 18%Cr-8%Ni stainless steels for high temperature service

Features

- Designed for welding with 100% CO₂ or Ar+15~25%CO₂ shielding gas
- Excellent all position weldability
- Smooth and stable arc with a fast freezing slag

Welding Position



Current

DC +

Shielding Gas

100% CO₂ / Ar+20~25% CO₂

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Nb
100% CO ₂	0.053	0.68	1.09	0.014	0.009	18.5	10.2	0.02
80% Ar + 20% CO ₂	0.050	0.63	1.00	0.019	0.008	19.1	10.2	0.02

Typical Mechanical Properties of All-Weld Metal

	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
100% CO ₂	580 (84,100)	41.0	-60 (-76)	52 (38.3)
80% Ar + 20% CO ₂	585 (54,825)	42.0	-60 (-76)	53 (39.1)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO ₂	20 (4/5)	6.5 (256)	140	23-26	2.6 (5.7)
		9.2 (362)	180	27-30	3.7 (8.2)
		12.5 (492)	210	28-31	4.8 (10.6)
80% Ar + 20% CO ₂	20 (4/5)	6.2 (244)	140	23-26	2.7 (6.0)
		9.0 (354)	180	27-30	3.7 (8.2)
		12.0 (472)	210	27-30	4.9 (10.8)

Diam.	15 kg Spool
1.2mm	HKSW308HBF12

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