

## GMAW Solid Wire for Stainless Steel

# KMS-308H

### Classification

AWS	A5.9/A5.9M	ER308H
JIS	Z3321	YS308H
EN	14343-A	G 19 9 H
YB	T5092	H07Cr21Ni10

Shielding Gas: Ar+1~2%O<sub>2</sub>(CO<sub>2</sub>)

### Applications and Features

- ( 1 ) Weld metal is austenitic structure with 19%Cr-9%Ni.
- ( 2 ) The high carbon deposit provides creep strength and a high tensile strength at elevated temperatures
- ( 3 ) Suitable for welding AISI 302, 304H and 305 unstabilized austenitic stainless steel.

### Welding Position



### Welding Instruction

- ( 1 ) Use Ar+1~2%O<sub>2</sub> for spray transfer and Ar+1~2%CO<sub>2</sub> for short-circuit transfer.
- ( 2 ) For other instructions, please refer to Appendix B and F.

### Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni
0.06	0.38	1.82	0.013	0.011	19.62	9.51

### Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm <sup>2</sup>	Yield Strength N/mm <sup>2</sup>	Elongation %
600	440	42

### Size and Suggested Operating Range (DC+)

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6	
Ar+1~2%CO <sub>2</sub>	Current (A)	40~120	60~140	80~160	100~210	-	-
	Voltage (V)	15~20	15~21	16~22	17~22	-	-
Ar+1~2%O <sub>2</sub>	Current (A)	160~210	170~260	180~280	200~300	210~320	220~330
	Voltage (V)	24~28	24~30	24~30	24~30	24~32	24~32