

Gas Tungsten Arc Welding

TG-S308
FAMILIARC
Filler Rods and Wires for 308 Stainless Steel
Classification: ASME / AWS A5.9 ER308

JIS Z3321 Y308

Features : -Suitable for 18%Cr-8%Ni 308 stainless steel

Shielding Gas : Ar

Chemical composition of rod and wire (%) as per AWS

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Example	0.05	0.46	1.89	0.024	0.001	9.69	20.00	0.05	0.07
Guaranty	≤0.08	0.30~ 0.65	1.00~ 2.50	≤0.030	≤0.030	9.00~ 11.00	19.50~ 22.00	≤0.75	≤0.75

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	410	580	42	-196°C: 39

Recommended welding parameters

Dia.	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	50~85A	70~115A	95~145A	135~180A
VU, OH	45~80A	65~110A	85~135A	-

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

AB, NK, NV

Packages

Dia. (mm)	Length (mm)	Weight per tube (kg)	Weight per piece(g)
1.2	1000	5	9
1.6	1000	5	16
2.0	1000	5	25
2.4	1000	5	35
3.2	1000	5	63