

DESCRIPTION

Executive 308/308H wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Carbon content in the range of 0.04-0.08 provide higher strength at elevated temperatures.

Executive 308/308H has typical ferrite levels between 3-8FN as per WRC-92 and controlled limits of antimony, bismuth & boron.

APPLICATIONS & FEATURES

Executive 308/308H is used in pulp and paper, food and beverage equipment manufacturing, petrochemical, and general manufacturing and fabrication.

Executive 308/308H is used for high temperature applications that are benefited by a higher carbon content in the weld.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N	B	Bi	Sb
0.057	19.53	9.25	0.19	1.53	0.49	0.025	0.018	0.15	0.064	<0.001	<0.001	<0.001

Tensile Strength: 87,000 PSI min

Elongation: 42.3%

Ferrite Range: 5-8 FN (WRC-92)

Yield Strength: 64,800 PSI min

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
GMAW - Short	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar	
	.045"	22-23	180-210			
	.062"	23-24	200-220			
	- Spray	.035"	23-25			190-260
		.045"	25-28			250-330
	.062"	28-31	310-350			
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
SAW	.093"	29-32	300-350		Record IND 24 or Record IN	
	.125"	29-32	400-550			

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER308/308H**

Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.

