

MT- 308 H

MIG/TIG wire with high carbon content, for welding high temperature resistant steels.

High temperature resistant up to +700°C.

Standard designation

EN ISO 14343-A	G 19 9 H/W 19 9 H
AWS/ASME SFA-5.9	~ER 308 H

Main base metals

Stainless steel austenitic Cr-Ni steel / cast steel, e.g.

1.4948 X 6 Cr Ni 18 11

1.4878 X 12 CrNiTi 18 9

1.4550 X 6 CrNiNb 18 10

Mechanical properties of all – weld – metal (typical values)

Welding process Gas shield Thermal treatment Test temperature	[°C]	TIG I1 untreated		MIG M 11 untreated	
		+20°C	-196°C	+20°C	-196°C
0,2%-yield strength R _{p0,2}	MPa	320		320	
1,0%-yield strength R _{p1,0}	MPa	350		350	
Tensile strength R _m	MPa	500		500	
Elongation A ₅	[%]	35		35	
Impact strength A _v	[J]	70		70	

Average chemical composition of all weld – metal (%)

C	Si	Mn	Cr	Ni
0,04-0,08	0,65	1,0-2,5	19,5-22,0	9,0-11,0

Structure

Austenite with 5% ferrite

Gas types applicable TIG

I1

Gas types applicable MIG

M 11, M 23

TIG rod diameters, unit weights

Diameter [mm]	Length [mm]	Kg per box [kg]
1,60	1000	10,0
2,00	1000	10,0
2,40	1000	10,0
3,20	1000	10,0

MIG welding wire

Diameter 0,8mm 1,0mm 1,2mm 1,6mm

Welding positions MIG acc.to EN ISO 6947

PA, PB, PF

Welding positions TIG acc.to EN ISO 6947

PA, PB, PC, PF, PE

Current/Polarity TIG

= -

Current/Polarity MIG

= +