

Unibraze 308/308H

CLASSIFICATIONS: AWS A5.9/ASME SFA 5.9 Class ER308/ER308H UNS S30880

DESCRIPTION:

Unibraze 308/308H is used for TIG, MIG, and submerged arc welding of 304 and 304H stainless steels. The higher carbon content gives higher strength at elevated temperatures, but with some sacrifice in corrosion resistance.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu	FN
.04-.08	19.5-22.0	9.0-11.0	.50 max	1.0-2.5	.30-.65	.03 max	.03 max		.75 max	8 (WRC)

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	88,500 psi (610MPa)
Yield Strength	59,500 psi (410 MPa)
Elongation	39%
Charpy Impacts@-320°F	45 ft lbs

TYPICAL WELDING PARAMETERS:

	Shielding Gas	Gas Flow	Diameter	Voltage	Amperage
MIG	98/99% Ar +2/1% O 97%Ar + 3% CO ₂	30 to 50 CFH	.035" (.9mm)	26-29	160 /210
			.045" (1.14mm)	28-32	180/250
			.062" (1.6mm)	29-33	200/280
TIG	100% Ar		1/16" (1.6mm)	14-18	90/130
			3/32" (2.4mm)	15-20	120/175
			1/8" (3.2mm)	15-20	150/220
SUBARC	Suitable Flux		3/32" (2.4mm)	28-33	275/350
			1/8" (3.2mm)	29-32	350/450

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.