



Unibraze 308-16/308H-16

CLASSIFICATIONS: AWS A5.4/ASME SFA 5.4 Class E308-16/E308H-16 UNS W30810

DESCRIPTION: Unibraze 308-16/ 308H-16 is an all position stainless steel electrode that is the same as E308-16 except the carbon content is restricted to .04 minimum. The carbon restriction provides higher tensile and creep strengths at elevated temperatures. Unibraze 308-16/308H-16 is suitable for welding 304H. Weld metal ferrite is targeted to 5 FN to minimize the effect of sigma embrittlement in high- temperature service.

Typical Chemistry:

	C	Cr	Ni	Mo	Mn	Si	P	S	Cu	FN (WRC)
AWS/ ASME	.04- .08	18.0- 21.0	9.0- 11.0	.75 max	.5- 2.5	1.0 max	.04 max	.03 max	.75 max	Not Required
Typical (As welded)	.044	19.05	10.03	.061	.67	.81	.022	.018	.096	2-4

Typical Mechanical Properties:

	AWS/ASME	Typical
Tensile Strength	80,000 psi (550 MPa) min.	89,198 psi (615 MPa)
Yield Strength	Not required	-
Elongation	35% min.	45%

Typical Welding Parameters: (DCEP or AC)

Dia.	Amps Flat	Amps Out of Position	Voltage
3/32"	70-90	65-80	20-23
1/8"	80-110	75-95	21-24
5/32"	110-160	100-120	22-25
3/16"	120-190	110-130	23-26

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.