



Unibraze 308H-T1

All Position

AWS A5.22/ASME SFA 5.22 E308HT-1, E308HT1-4, E308T-1, E308T1-4 UNS W30831

Unibraze 308H-T1 is a gas-shielded, flux cored, stainless steel designed to weld in all positions. It has a nominal weld metal composition of 20% Cr, 10% Ni and a carbon content of .04 to .08%. The higher carbon content in Unibraze 308H-T1 provides high tensile and creep strength at elevated temperatures. It is typically used for welding 304H Base material. It is designed for use with 100% CO₂ or a blend of 75-80% Argon/Balance CO₂. Shielding gas mixtures with more than 75-80% Argon is not recommended.

Typical Weld Deposit Chemistry: (100% CO₂)

C	Cr	Ni	Mn	Si	P	S	Cu	Mo
.04- .08	18.0- 21.0	9.0- 11.0	0.5- 2.5	1.0 max	.04 max	.03 max	.5 max	.5 max

Typical Mechanical Properties: (100% CO₂)

Tensile Strength	87,000 psi
Yield Strength	64,500 psi
Elongation	42%

* Strength levels will be slightly higher w/Ar+20-25% CO₂

Typical Welding Parameters: (100% CO₂)

Diameter	Amps	Volts	WFS (IPM)	Stick/Out
.045"	160-200	26-28	300-425	5/8" – 3/4"
.062" (1/16")	215-250	27-28	190-240	3/4" – 1"

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.