

Shield-Bright 308H

AWS A5.22 E308HT1-1(4) / JIS Z3323 TS308H-FB1

Flux
CORED
WIRES

Description and Application

- Shield-Bright 308H was developed for welding type 304H stainless steel and can also be used for welding type 301, 302, and 304 steels. It contains a higher carbon level than 308L filler metals to give greater high temperature strength. The ferrite content is also lower for high temperature service. It has greater ductility than 347 types at high temperatures and for that reason it is sometimes used to weld types 321 and 347 for service above 750°F (399°C) coupled with high stress. Shield-Bright 308H was designed for welding in all positions and performs particularly well in the vertical position with excellent slag removal.

Shielding Gas : 100%CO₂ or 75%Ar/25%CO₂

Typical Mechanical Properties of All Weld Metal

Shielding gas	Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)
100%CO ₂	392 {40}	578 {59}	44
75%Ar/25%CO ₂	430 {44}	600 {61}	42

Typical Undiluted Weld Metal Analysis %

Shielding gas	C	Mn	Si	P	S	Cr	Ni	Ferrite No.
100%CO ₂	0.050	1.10	0.80	0.020	0.007	19.3	9.5	3-8
75%Ar/25%CO ₂	0.060	1.20	0.90	0.020	0.070	19.5	9.8	3-8

Approvals

JIS