

Solid Wire Rod for TIG Welding

BA-TIG 308H

Classification: EN ISO 14343-A:
SFA-5.9: **ER308H**

Main Application:

BA-TIG 308H is a solid wire rod for GTAW of 18% Cr – 10% Ni, austenitic stainless steels for service temperature up to +700°C, base material 1.4948/AISI 304H.

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9: (Weight Percent)

Wire rod	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-TIG 308H	0.05	0.4	1.8	0.2	10.0	20.0	0.020	0.013	0.1
ER308H acc. to AWS A5.9	0.04- 0.08	0.30- 0.65	1.0-2.5	0.50	9.0-11.0	19.5- 22.0	0.03	0.03	0.75

All - Weld Metal Mechanical Properties / Welding Data:

Heat Treatment	As Welded
Yield Strength Re, N/mm ² (ksi)	350 (51)
Tensile Strength Rm, N/mm ² (ksi)	550 (80)
Elongation A5 [%]	>35
Impact Energy ISO-V, J (ft lbs)	+20°C: 80 (59)
Current/polarity	DC -
Shielding Gas	ISO 14175: I1

Base Materials:

1.4948 X6CrNi18-11, 1.4878 X12CrNiTi18-9
AISI 304/304H, 321H, 347H

Package Forms:

5 kg carton boxes as standard package form for GTAW wire rods.

Diameter:

1,6 – 3,2 mm. Sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire Rod Surface:

Smooth finish free from surface defects and foreign matter.