

# Solid Wire Electrode for Submerged Arc Welding

# BA-WIRE 308H

**Classification:** SFA-5.9 / AWS A5.9 – ER308H

**Typical analysis and chemical composition acc. to AWS A5.9:** (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-WIRE 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

## Application:

BA-WIRE 308H is a submerged arc welding wire intended for welding 18% Cr – 10% Ni austenitic stainless steels for service temperature up to +700 °C, base material 1.4948/AISI 30H.

## Base Materials:

- 1.4948 X6CrNi18-11, 1.4878 X12CrNiTi18-9 AISI 304/304H, 321H, 347H  
Suitable fluxes: BF 38, WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

## Package forms:

Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

## Diameter:

1.6 – 4.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

## Wire electrode surface:

Smooth finish free from surface defects and foreign matter.