

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GF308H

Applicable Specification

JIS Z 3323 TS308H-BiF-FB0

AWS A5.22 E308HT0-1/4

● Applications and Characteristics

TASETO GF308H is used for welding of Type 304H for high temperature service. As ferrite content of welding metal is controlled to 3-8% in schaeffler's diagram, mechanical properties of weld metal in elevated temperature have been improved.

● Notes on Usage

* Please refer "Guideline for Welding Stainless Steel with GFW Wires".

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.045	0.45	1.43	0.022	0.005	9.88	19.22	0.02	0.02

● Ferrite Content of All Weld Metal

* Typical Ferrite Content :
6.3% (Schaeffler's Diagram)
7.1FN (DeLong's Diagram)
6.4% (Ferrite Scope)

● Mechanical Properties of All Weld Metal

	Test Temp.	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	Room Temp.	404	617	43.0
	300°C	319	453	27.1
	550°C	246	365	29.3
	600°C	244	331	25.0
	650°C	215	270	35.2

● Creep Rupture Strength

	Test Temp. & Time	Strength
Typical	550°C × 1000h	240 MPa
	650°C × 1000h	127 MPa

● Absorbed Energy

	PWHT condition	Absorbed Energy
Typical	As welded	75 J
	650°C × 1000h	56 J
	750°C × 1000h	52 J

● Sizes Available, Shielding Gas

Size (mm)	Shielding Gas
1.2	CO ₂ or Ar+20%CO ₂ , 20L/min
1.6	CO ₂ or Ar+20%CO ₂ , 20L/min