THS-308 (ER308)

STAINLESS STEEL MIG WELDING WIRE

AWS A5.9 ER308
NB/T 47018 S308
GB/T 29713 S308
YB/H06Cr21Ni10

APPLICATION

Welding 12Cr18Ni9 (SUS302), 06Cr19Ni10 (SUS304), and similar materials.

CHARACTERISTICS

THS-308 is a 21% Cr-10% Ni austenitic stainless steel filler wire with a stable arc, good bead appearance, and all-position welding capability. The deposited weld metal has good resistance to intergranular corrosion.

PRECAUTIONS

Remove rust, oil, moisture, and other contaminants from the workpiece before welding. Use Ar + 1-3% O_2 shielding gas for MIG welding. Establish a suitable welding procedure for the actual production conditions.

WELDING POSITIONS



MECHANICAL PROPERTIES

Items	Tensile strength (MPa)	Elongation (%)
Typical results	600	40

WIRE CHEMICAL COMPOSITION (%)

Items	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
Requirements	≤0.08	1.00-2.50	0.30-0.65	19.50-22.00	9.00-11.00	≤0.75	≤0.025	≤0.020	≤0.75
Typical results	0.04	1.82	0.46	21.00	10.50	0.06	0.018	0.014	0.01