MIG 20/10C

Old reference: MIG 308H

Classification

ISO 14343-A : G 19 9 H
AWS A5.9 : ER308H

Material N° : 1.4948

Description & Applications

Solid wire electrode for Gas Metal Arc Welding of austenitic stainless steels like 304H, 308H, 321H and 347H grades with increased content of carbon. Mainly used for assemblies resistant to oxidation and creep at service temperatures between 400 and 750°C.

Base materials

Stainless steels for high temperature services:

UNS	Alloy	EN 10088	Material N°
S30409	304H	X6CrNi18-10	1.4948
S32109	321H	X8CrNiTi18-10	1.4878
S34709	347H	X7CrNiNb18-10	1.4912

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe	FN
0.05	0.4	1.8	19.9	9.7	0.2	0.1	<0.02	<0.015	Rem.	~6

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
380	580	35	+20°C 95

Welding Current & Instructions

Welding mode	Ø wire (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG =+	0.8 1.0 1.2 1.6	100-150 120-200 140-220 180-260	22-27 24-28 24-28 24-30	Ar + 2%CO2 Ar + 1%O2 18-20 l/min

Ind.10