



TIG 20/10C

Old reference: TIG 308H

Classification

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

Material.N° : 1.4948

Description & Applications

Solid low carbon rod for TIG welding of stainless steels (type 304H, 308H, 321H, and 347H). This type is generally reserved for creep-resistant pieces and oxidation resistance of working temperatures between 400° to 750° C.

The TIG process is particularly suited for welding of piping systems, works of fine thinness equal or inferior than 3 mm and for penetration passes.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	P	S	Fe
0.05	0.4	1.8	19.9	9.7	<0.02	<0.015	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	FN
380	580	35	+20°C 100	6

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

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