MG-S308 PREMIARC™

Solid wire

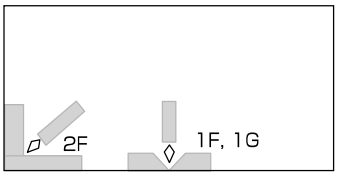
Features: ▪ Suitable for 18%Cr-8%Ni steel

Classification: AWS A5.9 ER308

Shielding gas: Ar-2%O_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool		Drum	
0.8	10kg	-	-	-
0.9	-	20kg	-	-
1.0	-	20kg	200kg	-
1.2	-	20kg	-	250kg
Volume mm	240W, 110H, 240L	285W, 110H, 285L	530ϕ, 820H	

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.04	0.08
Si	0.43	0.30~0.65
Mn	1.7	1.0~2.5
P	0.02	0.03
S	<0.01	0.03
Ni	9.7	9.0~11.0
Cr	19.9	19.5~22.0
Mo	0.08	0.75
Cu	0.11	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F
0.8	50~150
0.9	70~200
1.0	80~250
1.2	100~300

All-weld mechanical properties

	Typical
0.2%YS (MPa)	410
TS (MPa)	600
El on 4d (%)	40
IV -196℃ (J)	49