

CWR-308 Welding Wire and Rod

CWR-308 is used for welding a wide variety of unstabilized stainless steels such as type 301, 302, 304, 305 and 308. CWR-308 meets chemical requirements of both ER308 and ER308H. The higher carbon content, between .04% and .08%, in ER308H provide higher tensile and creep strength at elevated temperature.

CONFORMANCES

AWS A5.9/A5.9M	:	ER 308, 308H
ASME SFA-A5.9	:	ER 308, 308H
ISO 14343-B	:	SS 308, 308H

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Mn
0.04 – 0.08	19.5 – 22.0	9.0 – 11.0	0.50 max	1.0 – 2.5
0.05	20.1	9.7	0.08	1.8
%Si	%P	%S	%Cu	Total Others
0.30 – 0.65	0.03 max	0.03 max	0.75 max	0.50 max
0.43	0.02	0.01	0.11	

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	61,000 psi
Tensile Strength	:	90,000 psi
Elongation	:	40 %

TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 18	80 – 150	100% Ar
	3/32"	2.4 mm	15 – 20	150 – 250	100% Ar
	1/8"	3.2 mm	16 – 20	200 – 375	100% Ar
MIG (GMAW)	.035"	0.9 mm	23 – 29	170 – 290	98%Ar – 2%O ₂
	.045"	1.1 mm	24 – 30	200 – 360	98%Ar – 2%O ₂
Sub Arc (SAW)	.093"	2.4 mm	28 – 32	250 – 450	
	.125"	3.2 mm	29 – 34	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

<p>IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED</p> <p>BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.</p>

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