AI-1708H

Specifications

AS/NZS 14343 B SS308H
AWS/ASME A5.9/A5.9M ER308H

Description and Applications

AI-1708H is austenite structure with 20% Cr and 10% Ni.
AI-1708H has good strength at high temperature due to higher carbon content and is suitable for welding 308H steel.

Typical Weldmetal Analysis

C	Mn	Si	Cr	P	Ni
0.061	1.82	0.38	19.64	0.013	10.03

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	600 MPa
Yield Strength	440 MPa
Elongation	42%
Shielding Gas	**98% Ar + 2% O_2**

Welding Instructions

Use Argon blend with 1-2%O_2 for high current spray transfer welding.
Use Argon blend with 1-2%CO_2 for low current, short-circuit transfer welding.

Welding Parameters

Diameter (mm)	Current type	Amp
0.9	DC/AC	90-150
1.2	DC/AC	150-220

Available in 15Kg Spool

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position

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