

AI-1708H

Specifications

AWS A5.9/A5.9M ER308H

AS/NZS 14343 B SS308H

Description and Applications

AI-1708H weld metal is austenite structure with 20%Cr-10%Ni. It has good strength at high temperature due to the higher carbon content.

Applications: It is suitable for welding AISI 304, 304H and 308H Steel.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	P	S
0.061	1.82	0.38	19.64	10.03	0.013	0.011

Mechanical Properties of Weldmetal (Shielding Gas 98% Ar + 2%O₂)

	As Welded
Tensile Strength	600 MPa
Yield Strength	440 MPa
Elongation	42%

Welding Parameters

Diameter (mm)	Shielding Gas	Current type	Volts	Amps
0.9	98%Ar+2%CO ₂	DC+	15-21	60-140
	98%Ar+2%O ₂		24-30	170-260
1.2	98%Ar+2%CO ₂	DC+	17-22	100-210
	98%Ar+2%O ₂		24-30	200-300

15kg Spools

Welding Instructions

Use 98% Ar blend with 2% O₂ for high current spray transfer welding.

Use 98% Ar blend with 2% CO₂ for low current, short-circuit transfer welding.

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au



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