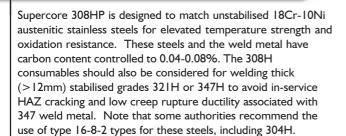
## PRODUCT DATA SHEET

## **SUPERCORE 308HP**





#### **CLASSIFICATIONS**

ı				
ı	AWS	A5.22	E308HT1-4	

#### **CHEMICAL ANALYSIS**

0.050	
1.300	
0.500	
0.010	
0.020	
	1.300 0.500 0.010

% Chromium	18.80	
% Nickel	9.500	
% Molybdenum	0.100	
% Copper	0.100	
% Ferrite	5	

# TYPICAL MECHANICAL PROPERTIES ALL WELD METAL

Tensile Strength	620 MPa	
0.2% Proof Stress	420 MPa	
Elongation on 4d	40%	
Impact Energy 20°C	100 J	

#### **Microstructure**

Austenite with delta ferrite controlled 2-8FN.

### **PACKING DATA**

(DC+)

Diameter (mm)	Current (A)		Stickout (mm)	Item Number	Pack Mass (Kg)
	Amps	Volts			
1.20	140 - 250	23 - 32	12 - 20	081-103	15

Suggested gas for FCW welding: Fluxshield

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