

Shield-Bright 308H

Shield-Bright 308H was developed for welding Type 304H stainless steel and can also be used for welding Type 301, 302, and 304 steels. It contains a higher carbon level than 308L filler metals to give greater high temperature strength. The ferrite content is also lower for high temperature service. It has greater ductility than 347 types at high temperatures and for that reason it is sometimes used to weld Types 321 and 347 for service above 750°F (399°C) coupled with high stress.

Classifications Weld Metal	SFA/AWS A5.22 : E308HT1-4 SFA/AWS A5.22 : E308HT1-1 JIS Z 3323 : YF 308C KS D 3612 : YF 308C EN ISO 17633-A : T 19 9 H P M21 2 JIS Z 3232 : TS308H-FB1
Classifications	SFA/AWS A5.22 : E308HT1-4 SFA/AWS A5.22 : E308HT1-1 JIS Z 3323 : YF 308C KS D 3612 : YF 308C EN ISO 17633-A : T 19 9 H P M21 2 JIS Z 3232 : TS308H-FB1 EN ISO 17633-A : T 19 9 H P C1 2
Industry	Industrial and General Fabrication Petrochemical Power Generation

Welding Current	DC+
Alloy Type	C Cr Ni
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties

Yield Strength	Tensile Strength	Elongation
M21 Shielding Gas		

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	-29 °C (-20 °F)	47 J (35 ft-lb)
As Welded	-196 °C (-321 °F)	26 J (19 ft-lb)
C1 Shielding Gas		
As Welded	-29 °C (-20 °F)	47 J (35 ft-lb)
As Welded	-196 °C (-321 °F)	26 J (19 ft-lb)

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm (0.045 in.)	130-220 A	24-29 V	5.8-14.4 m/min (228-567 in./min)	1.9-4.6 kg/h (4.2-10. lb/h)