

Stainless Steel Flux Cored Wire

GMX308H

AWS A5.22 E308HT1-1/4
A5.22M E308HT1-1/4
JIS Z 3323 TS308H-FB1

Product Features:

- GMX308H is especially developed for out-of-position welding. The smooth weld metal transfer and easy slag removal eliminates unnecessary clean up. The weld bead is uniform, flat to slightly convex and free from porosity.
- Penetration is complete and easy to obtain the flat equal weld leg.
- For welding types of 301, 302, 304, 304H, 305, 308 steel. The content of higher carbon provide higher tensile and creep strength at elevated temperature.

Guideline in Usage :

- Use general CO₂ welding machine, but loosen the wire-feeding roller.
- This wire is formulated for using 75% Argon plus 25% CO₂ gas shielded or straight CO₂ gas. However, the 75%Ar / 25%CO₂ mixture gas will produce a smoother arc with less spatter and slight higher yield and tensile strength.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.03	0.64	1.7	9.83	19.42	0.22	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
464	605	37

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat position	160~250	220~300
	Vertical up position	90~130	-
Shielding Gas		CO ₂ /80%Ar+20%CO ₂	CO ₂ /80%Ar+20%CO ₂

Note:

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