

# SpecMet CSF-308H • CSF-308HP

AWSA5.22 E308HTO-1 • AWSA5.22 E308HT1-1

## Applications

CSF-308H is a substitute for welding of 304H and 304H derivatives, which operate at temperatures up to 750°C

## Characteristics

1. Rutile flux cored stainless steel wire for gas shield welding
2. 19% chromium – 9% nickel – high carbon deposit
3. Attractive bead appearance, automatic slag release, very good penetration and high productivity
4. Excellent x-ray soundness
5. Maximum performances in horizontal and downhand positions
6. Can be used out of position
7. Welded with classical economical Air-CO<sub>2</sub> mixtures or CO<sub>2</sub>

## Typical Chemical Composition of Weld Metal (%)

Product Name	C	Si	Mn	P	S	Ni	Cr
CSF-308H	0.06	0.8	1.4	0.020	0.008	10.5	20.5

## Typical Mechanical Properties of Weld Metal (%)

Product Name	Rm (Mpa)	A%	KCV (J)
CSF-308H	575	35	80 @ +20°C

## Shielding Gas

M21 gas mixtures (Ar + 5 - 25% CO<sub>2</sub>) or C1 (CO<sub>2</sub>) according to EN439

## Size and Recommended Current Range (DC+)

Dia (mm)	Current Type	Intensity (A)	Voltage (V)	Stick Out (mm)	Gas Flow
0.9	DC (+)	80-180	18-28	12-20	10-20 l/min
1.2	DC (+)	100-270	18-35	12-25	10-20 l/min
1.6	DC (+)	150-400	22-37	12-25	10-20 l/min

## Packing

<b>Diameter</b>	0.9mm	1.2mm	1.6mm
<b>Weight</b>	15kg	15kg	15kg

Positions: ASME IX: 1G, 1F, 2G, 2F, (3G, 3F, 4F, 4G)