

# Gas Metal Arc Welding

JIS Z3321 Y308  
 AWS A5.9 ER308  
 DIN 8556-SG 1.4302

## MS M-308 Solid Wires for Stainless Steel

**Applications** Suitable for 18%Cr-8%Ni, 19%Cr-9%N and 20%Cr10%N stainless steel.  
 Used to weld base metals of similar composition in particular type 304

Brand Name		MS M-308							
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	-
	≤ 0.08	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	9.0-11.0	19.5-22.0	-	-
Mechanical property of deposited metal									
Tensile strength	≥ 550 N/mm <sup>2</sup>								
0.2% Offset strength	≥ 225 N/mm <sup>2</sup>								
Elongation	≥ 35 %								
Impact test	2mm Vnotch Impact value at -196° C 49 J								
Welding position	Horizontal/Flat position								
Welding polarity	DC-EP								
Shielding gas	98%Ar - 2%O <sub>2</sub>								
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm				
	80-180A	120-200A	140-250 A	170-300 A	200-350A				
Packing	12.50 kgs standard other packing weight can be provided upon request.								