

# YT-304H/T-304H

For SUPER304H™ (18%Cr-9%Ni-3%Cu-N)

## APPLICATIONS

Welding of SUPER304H™ (18%Cr-9%Ni-3%Cu-N)

## CHARACTERISTICS

YT-304H & T-304H are filler rods and spool wire for GTAW (TIG Welding) to be used with Ar shielded gas. The chemical compositions of this product are specially designed to reduce hot cracking, which is often occurred in welding of full Austenitic stainless steel.

T-304H is the product certified by TÜV.

## GUIDELINES FOR USAGE

1. Arc length should be kept as short as possible during welding.
2. Shield Gas : 100% Ar
3. All water, rust and oil in groove should be completely removed to prevent cracks and blowholes.

## WELDING POSITION



SUPER304H is a trademark of NIPPON STEEL CORPORATION.

## ■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL ( % )

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	N	Nb+Ta
0.07	0.22	3.18	0.005	0.004	2.60	15.7	17.6	0.8	0.17	0.6

## ■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength, MPa	Tensile Strength, Mpa	Elongation, %	Charpy 2V-notch at -10°C, J
617	657	25	118

## ■ SIZES

Dia. (mm)	0.8	1.0	1.2	1.6	2.0	2.4
Length of Filler Rod(mm)	—	—	—	1000	1000	1000
Weight of Spool wire(kg)	5	10	10	—	—	—

Identification color: End-green, secondary (engraving)-304H