INOX 308H

Electrodes MMA [SMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 3581-A : E 19 9 HR 42 DIN 8556 : E 19 9 R 42 AWS A-5.4 : E 308H-16 W.Nr. : 1.4316		Petrochemical and chemical industry

- Rutile electrode with increased carbon content with an alloyed core.
- For welding homogeneous steels exposed to chemical agents.
- The joint can be polished to a high gloss.
- For operating temperatures up to 700[°C].
- High resistance to brittleness in the sigma phase.

Base material

EN 10088 - 1/2	W.nr.	AISI/ASME	
X6 CrNi 18 11	1.4948	304H	
X12 CrNiTi 19 9	1.4878	321H	
X7 CrNiTi18-10	1.4940		
X3 CrNiMoBN17 13 3	1.4910	316LN	

Typical chemical composition %

C	Si	Mn	Cr	Ni
0,04-0,08	0,80	1,00-2,00	19,50-22,00	9,00-11,00

Typical mechanical properties

Yield strength Re [N/mm2]	>350
Tensile strength Rm [N/mm2]	>550
Elongation A5 [%]	>30
Impact energy Kv [J]	>70 J (20°C) /
Hardness	180-200HB /
Coating type	rutile
Welding current	
Welding positions	
Redrying	300 - 350°C / 1 h
Additional description	Austenitic microstructure with ferrite content at the level of 3-8 FN. Interpass temperature is about 150°C.

Welding parameters and packing

		[A]	[kg]	[kg]
2,5	300 /	50 - 75	1,0	6,0
ø	Length [mm]	Welding current	Weight of packet	Weight of carton
3,2	350 /	85 - 120	1,5	6,0
4,0	350 /	120 - 160	1,5	6,0

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