Selectarc Inox 308H

Rutile type Stainless Steel Electrode
With increased carbon

Classification

AWS A5.4 : E308H-17 ISO 3581-A : E 19 9 H R 3 2

Description & Applications

Austenitic stainless steel electrode, rutile-basic coating type with approx. 6% Delta ferrite (Ferrite WRC 1992 : 4) and increased carbon content. Stable arc, good slag removal, regular weld beads. Good behaviour in positional welding and on bad prepared joints. Excellent mechanical properties. Used on 18/8 stainless steels (304H- type) for elevated service temperatures up to + 750°C.

Main applications: Petrochemical industry: tubes, heat exchangers, piping systems.

Base materials

Stainless steels for high temperature applications:

UNS	*Alloy*	*EN 10088*	*Material N°*	*UGINE*
S30409	304H	X6CrNi18-11	1.4948	
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B, D, E
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
		X10CrNiTi18-10	1.6903	
		X10CrNi18-8	1.4310	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	O/T	Fe
0.05	0.8	0.8	19.0	9.5	0.1	0.1	<0.025	<0.020	<0.50	Rem.

All Weld Metal Mechanical Properties

$Rp_{0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
≥ 380	≥ 560	≥ 35	+20°C ≥ 70

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	70	100	135

Redrying at 250°C during 1h if necessary. Interpass temperature : ≤ 150°C.

= +	~ 70V

FT En-156-141024