Selectarc Inox 308HB

Basic type Stainless Steel
Electrode with increased carbon

Classification

AWS A5.4 : E308H-15
ISO 3581-A : E 19 9 H B 4 2

EN 1600 : E 19 9 H B 4 2

Description & Applications

Austenitic stainless steel electrode, basic type coating with approx. 5% ferrite and increased carbon contend. 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	Fe
0.05	0.4	1.8	19.5	9.5	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>380	>560	>35	+20°C >80

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	70	90	120

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

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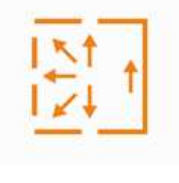

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