

**Technical
data sheet**

011121MBA

**Cored welding wire
TUBE S 308H-S****CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22	EC308H
EN ISO 17633-A	T Z 19 9 H M NO 3
Equivalent Material number	1.4948
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Cored stainless steel wire for submerged arc welding
- 19% chromium - 9% nickel - high carbon deposit
- Attractive bead appearance without residual slag, outstanding slag release
- Mineral additions to the core improve mechanical strength and welding characteristics
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

APPLICATIONS

TUBE S 308H-S is suitable for welding 304H and 304H derivatives that operate at temperatures up to 750°C.

Examples:

AISI	UNS	Material number	EN Symbol
304H	S30409	1.4948	X6 CrNi 18-11
321H	S32109	1.4941	X8 CrNiTi 18-10
347H	S34709	1.4961	X8 CrNiNb 16-13

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	S	P
0.06	1.40	0.55	20.5	10.5	0.008	0.020

Typical ferrite level: 5%

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
550	320	35	+20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
600	430	35	+20°C: 80

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

PACKAGING

Diameter	2.0 mm - 3.2 mm
Standard packaging	EN ISO 544 - ASME IIC SFA-5.2 M Coil: B450
Weight	25 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.