Technical data sheet 011121MBA	Cored welding wire # TUBE S 308H-S	Welding Alloys

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]	A_5 [%]	CVN [J]
550	320	35	+20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	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