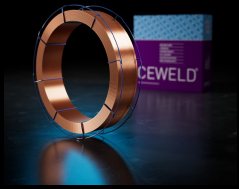


# CEWELD SA 308H

TYPE	Solid stainless steel wire for submerged arc welding (SAW). (Type 19 9 H, 1.4302)															
APPLICATIONS	Welding stainless steel types with an alloy content between 16 to 21%Cr and 8 to 13 %Ni, with high carbon content. The names 18-8, 19-9, and 20-10 are often associated with filler metals of this classification. Suitable for boilers, agriculture, liquid storage tanks, food machinery, furniture etc.															
PROPERTIES	Higher temperature and scale resistance than standard (L) types. Alloy has a high carbon content which make this alloy suitable for applications used at higher temperatures. Best to be used with our agglomerated flux CEWELD® FL 8111															
CLASSIFICATION	AWS	A 5.9: ER308H														
	EN ISO	14343-A: G 19 9 H														
	F-nr	6														
	FM	5														
	W.Nr.	1.4302														
SUITABLE FOR	<b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9 % Ni, TÜV 1000: Gr. 21,</b> 1.4301, 1.4308, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606 X 5 CrNi 18 10, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10 AISI 304, 304H, 312, 321H, 347, 347H, UNS S30409, S32109, S34709, S30400, S32100, S34700															
APPROVALS	No Approvals Found															
WELDING POSITIONS																
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.06</td> <td>0.5</td> <td>2</td> <td>0.2</td> <td>20.5</td> <td>10</td> <td>0.2</td> </tr> </tbody> </table>		C	Si	Mn	P	Cr	Ni	Mo	0.06	0.5	2	0.2	20.5	10	0.2
C	Si	Mn	P	Cr	Ni	Mo										
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> MPa</th> <th rowspan="2">R<sub>m</sub> MPa</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>RT</th> <th>-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>400</td> <td>610</td> <td>36</td> <td>120</td> <td>50</td> </tr> </tbody> </table>		Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		RT	-196°C	As Welded /	400	610	36	120	50
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			RT	-196°C												
As Welded /	400	610	36	120	50											
REDRYING TEMPERATURE	Not required															
GAS ACCORDING EN 14175																



# CEWELD SA 308H

SA 308H 3,2MM

Type	KG/unit	EANCode
K-415	25	8720663405449