




# 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	ISO 15608: 8.1 Austenit ≤ 19 % Cr 9 % Ni, TÜV 1000: Gr. 21, 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	<div> PA</div> <div> PB</div> <div> PC</div>						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	Cr	Ni	Mo
	0.06	0.5	2	0.2	20.5	10	0.2
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	RT	Impact Energy (J) ISO-V -196°C	
	As Welded /	400	570	36	120	50	
REDRYING TEMPERATURE	Not required						
GAS ACCORDING EN 14175							



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SA 308H 3,2MM

Type	KG/unit	EANCode
K-415	25	8720663405449