



CEWELD 308H

TYPE	Solid stainless steel filler metal with high carbon content for high temperature applications. (Type 19 9H, 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.														
PROPERTIES	CEWELD 308H has been developed for typical operating temperatures up to 400°C, and up to 600°C in the short-term range. It also shows good resistance to general corrosion. CEWELD 308H shows higher temperature and scale resistance than the standard L-type. The microstructure is austenite with approx. 5-10% ferrite.														
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER308H</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 19 9 H</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4302</td> </tr> </table>	AWS	A 5.9: ER308H	EN ISO	14343-A: G 19 9 H	F-nr	6	FM	5	W.Nr.	1.4302				
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F-nr	6														
FM	5														
W.Nr.	1.4302														
SUITABLE FOR	<p>ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9 % Ni, TÜV 1000: Gr. 21, 1.4301, 1.4308, 1.4948, 1.4878, 1.4940, 1.4912, 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</p>														
APPROVALS	CE														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">C</td> <td style="width: 25%;">Si</td> <td style="width: 25%;">Mn</td> <td style="width: 25%;">Cr</td> <td style="width: 25%;">Ni</td> </tr> <tr> <td>0.06</td> <td>0.6</td> <td>1.4</td> <td>20</td> <td>10</td> </tr> </table>	C	Si	Mn	Cr	Ni	0.06	0.6	1.4	20	10				
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>-40°C</th> <th>-196°C</th> </tr> <tr> <td>As Welded /</td> <td>460</td> <td>640</td> <td>38</td> <td>150</td> <td>90</td> </tr> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		-40°C	-196°C	As Welded /	460	640	38	150	90
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		-40°C	-196°C												
As Welded /	460	640	38	150	90										
REDRYING TEMPERATURE	Not required														
GAS ACCORDING EN 14175	M11, M13, M12														



CEWELD 308H

308H 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663412720
D-200	5	8720663412737

308H 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663412744
D-100	1	8720663412751

308H 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663412706

308H 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663412713