CEWELD AA 308H

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile fluxcored stainless steel wire with high carbon content. (Type 308H, 19 9)

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

Smooth drop transfer and stable arc with no spatter losses. Excellent productivity and weldability, better wetting properties compared to solid wires.Excellent weld metal quality and X-ray soundness and excellent slag removal.Excellent for use in horizontal and down hand position

CLASSIFICATION

AWS	A 5.22: E308HT0-4
AWS	A 5.22: E308HT0-1
EN ISO	17633-A: T 19 9 H R M21 3
F-nr	6
FM	5
W.Nr.	1.4302

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 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

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.9	1	0.015	0.008	19	10	0.3

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
As Welded /	450	630	36	80

REDRYING TEMPERATURE

140°C / 24 hr

GAS ACCORDING EN 14175

M21