



# CEWELD AA 308H

|                                             |                                                                                                                                                                                                                                                                                                                                                                                       |                                      |                      |                    |                         |    |    |          |
|---------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|----------------------|--------------------|-------------------------|----|----|----------|
| 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, A 5.22: E308HT0-1 |                      |                    |                         |    |    |          |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                | 17633-A: T 19 9 H R M21 3            |                      |                    |                         |    |    |          |
|                                             | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                 | 1.4302                               |                      |                    |                         |    |    |          |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                                                  | 6                                    |                      |                    |                         |    |    |          |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                    | 5                                    |                      |                    |                         |    |    |          |
| SUITABLE FOR                                | <b>ISO 15608: 8.1 Austenitic <math>\leq</math> 19 % Cr 9 % Ni, , TÜV 1000: Gr. 21</b><br>1.4301, 1.4308, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606<br>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<br>AISI 304, 304H, 312, 321H, 347, 347H,<br>UNS S30409, S32109, S34709, S30400, S32100, S34700 |                                      |                      |                    |                         |    |    |          |
| APPROVALS                                   | CE                                                                                                                                                                                                                                                                                                                                                                                    |                                      |                      |                    |                         |    |    |          |
| WELDING POSITIONS                           | <div>PAPBPCPF</div>                       |                                      |                      |                    |                         |    |    |          |
| 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      |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                        | R <sub>P0,2</sub> (MPa)              | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |    |    | Hardness |
|                                             |                                                                                                                                                                                                                                                                                                                                                                                       |                                      |                      |                    | RT                      |    |    |          |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                             | 450                                  | 630                  | 36                 | 80                      |    |    | HRc      |
| REDRYING                                    | 140°C / 24 hr                                                                                                                                                                                                                                                                                                                                                                         |                                      |                      |                    |                         |    |    |          |
| GAS ACC. EN ISO 14175                       | M21                                                                                                                                                                                                                                                                                                                                                                                   |                                      |                      |                    |                         |    |    |          |