



CEWELD SA 308H

TYPE Solid stainless steel wire for submerged arc welding (SAW)

APPLICATIONS Welding stainless steel types with an alloy content between 16 to 21%Cr and 8 to 13 %Ni, with high carbon content. Suitable for boilers, agriculture, liquid storage tanks, food machinery, furniture etc.

PROPRIÉTÉS 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
W.Nr.	1.4302
F-nr	6
FM	5

CONVIENT POUR **ISO 15608: 8.1 Austenitic $\leq$ 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

AGRÉMENTS

POSITIONS DE SOUDAGE



**ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL
D'APPORT (%)**

C	Si	Mn	P	Cr	Ni	Mo
0.06	0.5	2	0.2	20.5	10	0.2

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	400	610	36	120	50	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175



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SA 308H 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663405449