

S-308H.16

Type : Rutile

Conformances

AWS A5.4/ ASME SFA5.4 E308H-16

JIS Z3221 ES308H-16

EN ISO 3581-A-E 199 H 3 2

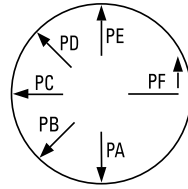
Applications

- Stainless steel (ASTM 304H, 304)

Features

- Good creep resistance
- Service temperature up to 700°C(1292°F)
- Easy to remove slag
- Low spatter
- Good bead appearance

Welding Position



Current

AC or DC ±

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	P.V.C	
		packet 2.5kg(5.5lbs)	carton 10kg(22lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	
6.0 (15/64)	450 (18)	✓	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni
0.05	0.65	0.90	0.03	0.02	18.9	9.9

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
590 (85,500)	40.0

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	25-55	50-85	70-115	95-145	135-180
V-up, OH	20-50	45-80	65-110	85-135	-