Product Data Sheet

E 'Manual metal-arc welding'

OK 61.25

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
A-C Thorsson	Tero Borg	Tapio Huhtala	EN007126	EN005954	2016-02-25	1 (2)

REASON FOR ISSUE

NAKS/HAKC approval added. Impact toughness at -18°C added. Nitrogen and Ferrite FN added to chemical composition. Hardness data provided under Other Data.

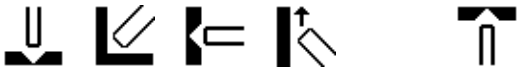
GENERAL

Basic coated stainless electrode of the 308H-type especially designed for high temperature applications.

Polarity: DC+

Alloy Type: Austenitic CrNi
Coating Type: Basic
Ferrite Content: FN 2-5

WELDING POSITIONS



1 2 3 4 6

CLASSIFICATIONS Electrode

EN ISO 3581-A	E 19 9 H B 2 2
SFA/AWS A5.4	E308H-15

APPROVALS

NAKS/HAKC	2.5-3.2 mm
Seproz	UNA 272580

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C	0.05	0.08	
Si	0.20	0.70	
Mn	1.0	2.0	
P		0.030	
S		0.020	
Cr	18.0	20.0	
Ni	9.0	11.0	
Mo		0.50	
Cu		0.50	
N		0.08	
Ferrite FN			4

MECHANICAL PROPERTIES OF WELD METAL

	AWS	AWS	
	PWHT 720°C 1000h	As welded	
Properties	**Typ**	**Min**	**Typ**
Rp0.2 (MPa)	300		430
Rm (MPa)	570	550	600
A4 (%)	45	35	45
Z (%)			50
Charpy V at 20°C (J)	100		95
Charpy V at -18°C (J)			83

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ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding
Ø x Length	Min	Max								Positions
2.5 x 300	55	85	1.7	104	0.62	93	0.9	47	23	1,2,3,4,6
3.2 x 350	75	110	3.4	104	0.59	49	1.2	66	23	1,2,3,4,6
4.0 x 350	80	160	5.1	104	0.61	32	1.8	68	24	1,2,3,4,6

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)

OTHER DATA

Hardness data:

As welded condition, all weld metal, transverse cross section of ISO joint, measurements done along a horizontal (5 indents)- and vertical line (10 indents), 2 samples tested: 171 - 230 HV10, average 203 HV10

Redrying 200°C, 2h.