



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 308H

Signed by Mats Linde	Approved by Per-Åke Pettersson/Christos Skodras	Reg no EN005030	Cancelling EN004134	Reg date 2009-11-23	Page 1 (1)
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REASON FOR ISSUE

Shielding Gas standard up date.

GENERAL

Bare corrosion resisting chromium-nickel rods for welding of austenitic chromium nickel alloys of 18 % Cr - 8 % Ni-type.

OK Tigrod 308H has a good general corrosion resistance. The alloy has a high carbon content which makes this alloy suitable for applications used at higher temperatures. The alloy is used in chemical and petrochemical industry for welding of for tubes, cyclones and boilers.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Austenitic 19% Cr - 9% Ni - High C

CLASSIFICATIONS Wire Electrode

EN ISO 14343 W 19 9 H
SFA/AWS A5.9 ER308H

APPROVALS

Not applicable

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C	0.04	0.08
Si	0.30	0.65
Mn	1.4	2.2
P		0.030
S		0.020
Cr	19.5	21.0
Ni	9.0	11.0
Mo		0.30
Cu		0.30
Others tot		0.50

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	Min
Rp0.2 (MPa)		350
Rm (MPa)		550
A4-A5 (%)		30