CEWELD 308H Tig

certilas® THE FILLER METAL SPECIALIST

TYPE	Stainless steel Tig welding wire with high carbon content
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	CEWELD 308H Tig has been developed for typical operating temperatures up to 400°C, and up to 600°C in the short-term range. It also shows good resistance to general corrosion. CEWELD 308H Tig shows higher temperature and scale resistance than the standard L-type. The microstructure is austenite with approx. 5-10% ferrite.

CLASSIFICATION

AWS	A 5.9: ER308H
EN ISO	14343-A: W 19 9 H
W.Nr.	1.4302
F-nr	6
FM	5

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 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

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni
0.05	0.5	1.5	0.01	0.01	20.2	10

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-40°C	-196°C	
As Welded	465	650	38	160	95	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

I1

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308H TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412669

308H TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412676

308H TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412683

308H TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412690