

## ROCKWELD 308H



Rockweld 308H is a rutile coated electrode for chromium-nickel steels of the 18Cr / 8 Ni type with carbon contents up to approximately 0.20%. Resistant to grain boundary disintegration at operating temperatures up to 300°C. Smooth bead appearance. Low spatter loss. Easy slag removal.

## CLASSIFICATIONS

AWS	A5.4	E308-16
EN	1600	E 19 9H R12

## CHEMICAL ANALYSIS

% Carbon	0.060
% Manganese	0.700
% Silicon	0.700
% Chromium	19.00
% Nickel	10.00

TYPICAL MECHANICAL PROPERTIES  
ALL WELD METAL

Tensile Strength	550 - 690 MPa
Yield Strength	>350 MPa
Elongation on 5d	>35%
Impact Energy 20°C	>50J

## Microstructure

Austenitic with approximately 5% delta ferrite.

## PACKING DATA

Diameter (mm)	Current (A)	Item Number	Pack Mass (Kg)
2.50	50-75	078-048	3 x 5
3.20	70-110	078-050	3 x 5
4.00	110-150	078-052	3 x 5

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