

SUBMERGED ARC CONSUMABLES

PRODUCT DATA SHEET

SUBARC 308H

(Flat and Fillet Pic's)

DESCRIPTION

Afrox Sub Arc 308H is designed to match unstabilised 18Cr 10Ni austenitic stainless steels for elevated temperature and oxidation resistance. These steels and the weld metal have a carbon content controlled to 0.04-.0.8%. The 308H consumables can also be considered for welding >12mm thick stabilised 321H or 347H to avoid in service HAZ cracking and low creep rupture associated with 347 weld metal.

CLASSIFICATION (Wire)

AWS	A5.9	ER308H
BS EN 12072		19 9 H
DIN 8556		SG X5CrNi 19 9

TYPICAL CHEMICAL ANALYSIS (Wire)

% Carbon	0.05	% Chromium	19.90
% Manganese	1.80	% Nickel	9.50
% Silicon	0.40	% Molybdenum	0.10
% Phosphorus	0.015	% Copper	0.10
% Sulphur	0.002		

TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL)

Flux	MK-SS
Tensile Strength (MPa)	620
2% Proof Stress (MPa)	450
Elongation 4d %	43
Charpy Impact Value J @+20°C	100

PACKING DATA & OPERATING PARAMETERS

SAW wire Diameter mm	Current (DC+ / AC)		Item Number	Pack Mass (Kg)
	Amps	Volts		
3.20mm	500	28	078385	25
4.00mm	550	28	078385	25

For more detail on the fluxes used, please refer to the relevant flux data sheet.

 **AFROX** For ordering, enquiries and basic product and safety advice – 0860 020202