

ESAB 308H

A high carbon 19/9 stainless steel electrode

Classification AWS A5.4: E 308H-16
 IS 5206: E 19.9 R26



DESCRIPTION

ESAB 308H is specially designed for welding of stainless steels with carbon content corresponding to AISI 308H type. ESAB 308H possess excellent arc and current carrying characteristics and provides a smooth and stable arc in all welding positions. The slag system is so designed to allow for a controllable fluid slag cover that provides for excellent wetting and an easily removable slag cover. The weldbead is smooth, even and shiny.

WELDING CURRENT: DC +, AC 65 V

TYPICAL APPLICATIONS

ESAB 308H finds wide use in the fabrication of components made out of AIS 308H type steels that are used for their high tensile strength e.g. in agricultural implements, automobile industries, construction segment, etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.07	Si	0.70	YS	440 N/mm ²
Mn	0.90	Mo	0.50	UTS	620 N/mm ²
Cr	19.00	S	0.018	EL (L=4d)	37%
Ni	10.00	P	0.018	Ferrite	4-8 FN

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	40-60	80	400
3.15	350	60-90	60	300
4.00	350	85-130	40	200
5.00	350	140-180	25	125

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.