

Standards

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| TS EN ISO 3581-A | : E 19 9 H B 22 |
| EN ISO 3581-A | : E 19 9 H B 22 |
| AWS A5.4 | : E 308 H-15 |

**Chemical Composition of
Weld Metal % (Typical)**

| C | Si | Mn | Ni | Cr |
|------|-----|-----|------|------|
| 0.05 | 0.6 | 1.4 | 10.5 | 19.0 |

Mechanical Properties

| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Impact Strength (ISO-V/+20°C) | Elongation (L ₀ =5d ₀) (%) |
|--|--|----------------------------------|--|
| min. 350 | min. 550 | min. 47 J | min. 30 |

Typical Base Material Grades

- 301,302,304, 304H, 305,321

Features and Applications

- A basic coating electrodes are used for welding type 304H and similar applications where creep strength is required
- Electrodes are the same as E308, except for carbon content that has been restricted in the range of 0.04 to 0.08
- It provides higher tensile and creep strength has at elevated temperatures
- Weld metal ferrite content is normally targeted for 5 FN to minimize effect of sigma embrittlement in high temperature service

Welding Positions

Current Type

D.C.(+)

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | | Welding Current (A) | Weight g / 100 pcs |
|--------------|------------------------------------|------------|------------------------|-----------------------|
| 3010101598 | 2.50 x 250 | 3/32 x 10" | 60 - 90 | 1500 |
| 3010101603 | 3.20 x 350 | 1/8 x 14" | 100 - 130 | 3300 |
| 3010101608 | 4.00 x 350 | 5/32 x 14" | 100 - 160 | 4750 |

Approvals: CE, SEPRO