

USA 308H-16 Coated Electrode

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ALLOY DESCRIPTION AND APPLICATION;

USA 308H electrodes contain higher carbon over 308 for the welding of austenitic, high carbon 18% Cr – 8% Ni stainless steels such as AISI-304-H. The weld deposit of this electrode contains a 0.04 - 0.08% carbon, which provides higher tensile and creep strengths at elevated temperatures. USA 308H electrodes have a high deposition rate resulting in excellent efficiency. This electrode may be used in all positions. USA 308H electrodes may be used joint welds in construction parts for chemical engineering and cryogenic applications.

TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps	Diameter	Amps
1/16"	15-40	1/8"	75-110
5/64"	30-50	5/32"	100-140
3/32"	50-75	3/16"	160-200

Arc Length = short arc, Flat use 15° angle from 90°, Vertical up & Overhead use weaving techniques within puddle

Procedures may vary with change in position, base metals, filler metals, equipment and other changes. When welding vertical reduce amperage 10-20%

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	0.05			
Manganese	0.75		Phosphorus	0.028
Silicon	0.35		Sulfur	0.025
Chromium	19.74		Nickel	9.92
		Elongation	44%	
		Yield Strength	(psi) 68.000	

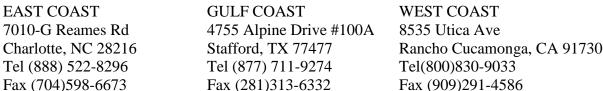
Tensile Strength (psi) 89,000

Iron balance and all single values are maximum percentages

AVAILABLE SIZES: TF308H-16 = 1.8"

SPECIFICATIONS; ANSI/AWS A5.4 E308H-16

ASME SFA 5.4 E308H-16



Warehouse Distribution Center – Dayton, Ohio Head Office – Puyallup, Washington

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