



# CEWELD SA 308H

**TYPE** Solid stainless steel wire for submerged arc welding (SAW). (Type 19 9 H, 1.4302)

**APPLICATIONS** Welding stainless steel types with an alloy content between 16 to 21%Cr and 8 to 13 %Ni, with high carbon content. The names 18-8, 19-9, and 20-10 are often associated with filler metals of this classification. Suitable for boilers, agriculture, liquid storage tanks, food machinery, furniture etc.

**PROPERTIES** Higher temperature and scale resistance than standard (L) types. Alloy has a high carbon content which make this alloy suitable for applications used at higher temperatures. Best to be used with our agglomerated flux CEWELD® FL 8111

**CLASSIFICATION**

AWS	A 5.9: ER308H
EN ISO	14343-A: G 19 9 H
W.Nr.	1.4302
F-nr	6
FM	5

**SUITABLE FOR**

**ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9 % Ni, TÜV 1000: Gr. 21,**  
 1.4301, 1.4308, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606  
 X 5 CrNi 18 10, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10  
 AISI 304, 304H, 312, 321H, 347, 347H,  
 UNS S30409, S32109, S34709, S30400, S32100, S34700

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

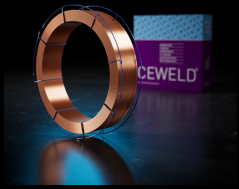
C	Si	Mn	P	Cr	Ni	Mo
0.06	0.5	2	0.2	20.5	10	0.2

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	400	610	36	120	50	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175**



# CEWELD SA 308H

SA 308H 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663405449