



# CEWELD 308H

TYPE	Fil de soudage 308H acier inoxydable à haute teneur en carbone pour des applications à haute température.																
APPLICATIONS	Soudage d'aciers inoxydables avec une teneur de 16 à 21 % Cr et de 8 à 13 % Ni, à haute teneur en carbone.																
PROPRIÉTÉS	Résistance à la température plus élevée que les types standards (L).																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER308H</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 19 9 H</td> </tr> <tr> <td>W.Nr.</td> <td>1.4302</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.9: ER308H	EN ISO	14343-A: G 19 9 H	W.Nr.	1.4302	F-nr	6	FM	5						
AWS	A 5.9: ER308H																
EN ISO	14343-A: G 19 9 H																
W.Nr.	1.4302																
F-nr	6																
FM	5																
CONVIENT POUR	<p><b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9 % Ni, TÜV 1000: Gr. 21,</b>            1.4301, 1.4308, 1.4948, 1.4878, 1.4940, 1.4912, 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</p>																
AGRÉMENTS	CE																
POSITIONS DE SOUDAGE																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 20%;">C</td> <td style="width: 20%;">Si</td> <td style="width: 20%;">Mn</td> <td style="width: 20%;">Cr</td> <td style="width: 20%;">Ni</td> </tr> <tr> <td>0.06</td> <td>0.6</td> <td>1.4</td> <td>20</td> <td>10</td> </tr> </table>	C	Si	Mn	Cr	Ni	0.06	0.6	1.4	20	10						
C	Si	Mn	Cr	Ni													
0.06	0.6	1.4	20	10													
PROPRIÉTÉS MÉCANIQUES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0.2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-40°C</th> <th>-196°C</th> </tr> <tr> <td>As Welded</td> <td>460</td> <td>640</td> <td>38</td> <td>150</td> <td>90</td> <td>HRc</td> </tr> </table>	Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	-40°C	-196°C	As Welded	460	640	38	150	90	HRc
Heat Treatment	R <sub>P0.2</sub> (MPa)					R <sub>m</sub> (MPa)	A <sub>5</sub> (%)		Impact Energy (J) ISO-V		Hardness						
		-40°C	-196°C														
As Welded	460	640	38	150	90	HRc											
ETUVAGE	non nécessaire																
GAS ACC. EN ISO 14175	M11, M13, M12																



# CEWELD 308H

## 308H 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412720
D-200	5	8720663412737

## 308H 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412744
D-100	1	8720663412751

## 308H 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412706

## 308H 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412713