



CEWELD AA 308H

TYPE	Rutile fluxcored stainless steel wire with high carbon content							
TOEPASSINGEN	Welding stainless steel types with an alloy content between 16 to 21% Cr and 8 to 13 % Ni, with high carbon content. High weld metal quality and attractive bead appearance							
EIGENSCHAPPEN	Smooth drop transfer and stable arc with no spatter losses. Excellent productivity and weldability, better wetting properties compared to solid wires.Excellent weld metal quality and X-ray soundness and excellent slag removal.Excellent for use in horizontal and down hand position							
CLASSIFICATIE	AWS	A 5.22: E308HT0-4						
	EN ISO	17633-A: T 19 9 H R M21 3						
	W.Nr.	1.4302						
	F-nr	6						
	FM	5						
GESCHIKT VOOR	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							
GOEDKEURINGEN	CE							
LASPOSITIES	PAPBPCPF							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo
	0.06	0.9	1	0.015	0.008	19	10	0.3
MECHANISCHE WAARDEN	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					RT			
	As Welded	450	630	36	80		HRc	
HERDROGEN	140°C / 24 hr							
GAS ACC. EN ISO 14175	M21							