

Classifications

EN ISO 3581-A	AWS A5.4
E 19 9 R	E308H-17

Characteristics and typical fields of application

Avesta 308/308H AC/DC is a high carbon Cr-Ni electrode primarily intended for welding 1.4948/ASTM 304H type stainless steels exposed to temperatures above 400°C.

Corrosion resistance:

Corresponding to 1.4301/ASTM 304, i.e. good resistance to general corrosion. The enhanced carbon content, compared to 308L, makes it slightly more sensitive to intergranular corrosion.

Base materials

Outokumpu	EN	ASTM	BS	NF	SS
4948	1.4948	304H	305S51	Z6 CN 18-09	2333
4301	1.4301	304	304S31	Z7 CN 18-09	2333
4541	1.4541	321	321S31	Z6 CNT 18-10	2337
-	1.4550	347	347S31	Z6 CNNb 18-10	2338

Typical analysis of all-weld metal (wt.-%)

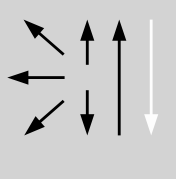
	C	Si	Mn	Cr	Ni
wt-%	0.06	0.7	1.1	20.0	10.0

Mechanical properties of all-weld metal

Heat-treatment	Yield strength R_e N/mm ²	Tensile strength R_m N/mm ²	Elongation ($L_0=5d_0$)	Impact work ISO-V KV J		Hardness
	MPa	MPa	%	+20 °C	-40°C	
u	465	605	35	50	-	200

u untreated, as-welded

Operating data

	Polarity: DC (+)	Electrode identification:	ø (mm)	L mm	Amps A
			2.5		50 – 80
			3.25		80 – 120
			4.0		100 – 160
			5.0		160 – 220

Approvals

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