

Classifications									
EN ISO 14343-A					AWS A5.9				
W Z 18 16 1 Cu H					ER308H(mod.)				
Characteristics and typical fields of application									
Joining and surfacing on matching austenitic creep resistant CrNi(N)-steels / cast steel grades with good high temperature corrosion resistance, stainless									
Base materials									
1.4907 – X10CrNiCuNb18-9-3: EN 10216-5; 18Cr-9Ni-3Cu-Nb-N: ASME SA-213; code case 2328-1 and comparable creep resistant, austenitic steels, Super 304 H, DMV 304 HCu									
Typical analysis of the TIG rods (wt.-%)									
	C	Si	Mn	Cr	Ni	Nb	Mo	Cu	N
wt-%	0.1	0.4	3.2	18.0	16.0	0.4	0.8	3.0	0.2
Structure: Austenite, non ferrite									
Mechanical properties of all-weld metal									
Heat-treatment	Yield strength R _{p0.2}	Yield strength R _{p1.0}	Tensile strength R _m		Elongation A (L ₀ =5d ₀)		Impact work ISO-V KV J		
	MPa	MPa	MPa		%		+20 °C		
aw	350	400	590		25		47		
Operating data									
Polarity:	Shielding gas:		Marks:			ø (mm)		L mm	
DC (–)	(EN ISO 14175) I1		✦ W Z 18 16 1 Cu H / 304HCu			1.6 2.0 2.4		1000 1000 1000	
Welding instruction									
Materials			Preheating			Postweld heat treatment			
Joining on matching / similar CrNi(N)-steels / cast steel grades			None			Mostly none. If necessary, solution annealing at 1100 °C (2012 °F)			
Approvals									
TÜV (11219), CE									