

Classifications

EN ISO 14343-A

AWS A5.9

W Z18 16 1 Cu H

ER308H (mod.)

Characteristics and typical fields of application

GTAW rod for high quality joints on similar austenitic creep resistant steels. The weld metal shows good high temperature corrosion properties.

Base materials

1.4907 – X10CrNiCuNb18-9-3

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.-%)

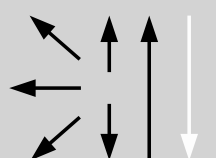
	C	Si	Mn	Cr	Ni	Nb	Mo	Cu	N
wt-%	0.1	0.4	3.2	18.0	16.0	0.4	0.8	3.0	0.2

Mechanical properties of all-weld metal

Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
u	≥ 350	≥ 590	≥ 25	≥ 32

u untreated, as welded – shielding gas Argon

Operating data

	Polarity: DC (–)	Shielding gases: 100 % Argon	Rod marking: front: † WZ 18 16 1 CuH back: 304 H Cu	ø (mm) 2.0 2.4
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Post weld heat treatment is normally not necessary. If needed solution annealing 1100 °C.

Approvals

TÜV (11548.), CE