

Classifications

EN ISO 14343-A	EN ISO 14343-B	AWS A5.9
W 19 9 H	SS308H	ER308H

Characteristics and typical fields of application

GTAW rod for high quality joints on high temperature austenitic CrNi-steels for service temperature up to +700 °C. Specially designed for the base metal AISI 304H (W. No.: 1.4948).

The controlled ferrite content ensures hot cracking resistance. The deposit is largely insusceptible to embrittlement.

Base materials

Similar alloyed creep resistant steels

1.4948 X6CrNi18-10, 1.4878 X8CrNiTi18-10, 1.4940 X7CrNiTi18-10, 1.4912 X7CrNiNb18-10
AISI 304H, 321H, 347H

Typical analysis of the TIG rods (wt.-%)

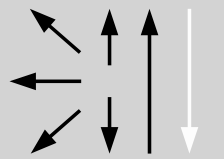
	C	Si	Mn	Cr	Ni			FN
wt-%	0.06	0.4	1.7	20.0	9.5			3-8

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	≥ 550	≥ 30	≥ 32

u untreated, as welded – shielding gas Argon

Operating data

	Polarity: DC (–)	Shielding gases: 100 % Argon	Rod marking: front: ✦ ER 308 H	∅ (mm) 2.0 2.4
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The interpass temperature should not exceed 200 °C.