

Standards:

EN ISO 3581-A: E 19 9 H R 12
 EN 1600: E 19 9 R 12
 AWS A 5.4: E 308 H-16
 Mat.-No.: 1.4948

capilla® 308 H

Product description:

Rutile-basic coated stick electrode suitable for fusion welding of heat resistant stainless austenitic steel grades without Nb or Ti.

Service temperatures: up to 700°C

Applications:

Suitable for welding steel grades like:

1.4948, 1.4878, 1.4550.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Fe
Min.		18	9	
Max.	0,03	20	11	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	550	[MPa]
Yield strength $R_{0,2}$:	320	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	35	[%]
Impact strength (ISO-V):	70	[J]

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	300	40 – 60	= (+)~
2,5	300	50 – 90	
3,25	350	80 – 110	
4,0	350	100 – 150	
5,0	450	150 – 200	

also available:
 find in table of content

Capilla 308 KB
 Capilla 308 L
 Capilla 308 LR

Capilla 308 MAG
 Capilla 308 WIG
 Capilla G 308 L RM (tubular wire)