

Classifications

high-alloyed

EN ISO 3581-A:

AWS A5.4:

E 19 9 R

E308H-17

Characteristics and field of use

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.

Base materials

For welding steels such as

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
0.06	0.7	1.1	20.0	10.0

Mechanical properties of all-weld metal

Heat Treatment	Yield strength 0.2%	Tensile strength	Elongation ($L_0=5d_0$)	Impact values in J CVN	
	MPa	MPa	%	+20°C:	-40°C:
untreated	450	605	37	55	50

Operating data



Polarity = + / ~

Dimensions (mm)

Amperage A

2.5 x 300	50-80
3.25 x 350	80-120
4.0 x 350	130-160
5.0 x 350	160-220