



# CEWELD 308H

TYPE	Solid stainless steel filler metal with high carbon content for high temperature applications. (Type 19 9H, 1.4302)																
APPLICATIONS	Welding stainless steel types with an alloy content between 16 to 21% Cr and 8 to 13 % Ni, with high carbon content. The names 18-8, 19-9, and 20-10 are often associated with filler metals of this classification.																
PROPERTIES	CEWELD 308H has been developed for typical operating temperatures up to 400°C, and up to 600°C in the short-term range. It also shows good resistance to general corrosion. CEWELD 308H shows higher temperature and scale resistance than the standard L-type. The microstructure is austenite with approx. 5-10% ferrite.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER308H</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 19 9 H</td> </tr> <tr> <td>W.Nr.</td> <td>1.4302</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.9: ER308H	EN ISO	14343-A: G 19 9 H	W.Nr.	1.4302	F-nr	6	FM	5						
AWS	A 5.9: ER308H																
EN ISO	14343-A: G 19 9 H																
W.Nr.	1.4302																
F-nr	6																
FM	5																
SUITABLE FOR	<p><b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9 % Ni, TÜV 1000: Gr. 21,</b>            1.4301, 1.4308, 1.4948, 1.4878, 1.4940, 1.4912, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606            X 5 CrNi 18 10, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10            AISI 304, 304H, 312, 321H, 347, 347H,            UNS S30409, S32109, S34709, S30400, S32100, S34700</p>																
APPROVALS	CE																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 20%;">C</td> <td style="width: 20%;">Si</td> <td style="width: 20%;">Mn</td> <td style="width: 20%;">Cr</td> <td style="width: 20%;">Ni</td> </tr> <tr> <td>0.06</td> <td>0.6</td> <td>1.4</td> <td>20</td> <td>10</td> </tr> </table>	C	Si	Mn	Cr	Ni	0.06	0.6	1.4	20	10						
C	Si	Mn	Cr	Ni													
0.06	0.6	1.4	20	10													
MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0.2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-40°C</th> <th>-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>460</td> <td>640</td> <td>38</td> <td>150</td> <td>90</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	-40°C	-196°C	As Welded	460	640	38	150	90	HRc
Heat Treatment	R <sub>P0.2</sub> (MPa)					R <sub>m</sub> (MPa)	A <sub>5</sub> (%)		Impact Energy (J) ISO-V		Hardness						
		-40°C	-196°C														
As Welded	460	640	38	150	90	HRc											
REDRYING	Not required																
GAS ACC. EN ISO 14175	M11, M13, M12																



# CEWELD 308H

## 308H 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412720
D-200	5	8720663412737

## 308H 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412744
D-100	1	8720663412751

## 308H 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412706

## 308H 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412713