



CEWELD 308H

| TYPE | Fil de soudage 308H acier inoxydable à haute teneur en carbone pour des applications à haute température. | | | | | | | | | | | | | | | | |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|-------------------------|----------------------|--------------------|-------------------------|--------------------|----------|-------------------------|--------|-----------|-----|-----|----|-----|----|-----|
| APPLICATIONS | Soudage d'aciers inoxydables avec une teneur de 16 à 21 % Cr et de 8 à 13 % Ni, à haute teneur en carbone. | | | | | | | | | | | | | | | | |
| PROPRIÉTÉS | Résistance à la température plus élevée que les types standards (L). | | | | | | | | | | | | | | | | |
| 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 | | | | | | | | | | | | | | | | |
| CONVIENT POUR | <p>ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9 % Ni, TÜV 1000: Gr. 21, 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> | | | | | | | | | | | | | | | | |
| AGRÉMENTS | CE | | | | | | | | | | | | | | | | |
| POSITIONS DE SOUDAGE | | | | | | | | | | | | | | | | | |
| 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 | | | | | | | | | | | | | |
| PROPRIÉTÉS MÉCANIQUES | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0.2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</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> <tr> <td>As Welded</td> <td>460</td> <td>640</td> <td>38</td> <td>150</td> <td>90</td> <td>HRc</td> </tr> </table> | Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | -40°C | -196°C | As Welded | 460 | 640 | 38 | 150 | 90 | HRc |
| Heat Treatment | R _{P0.2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | |
| | | -40°C | -196°C | | | | | | | | | | | | | | |
| As Welded | 460 | 640 | 38 | 150 | 90 | HRc | | | | | | | | | | | |
| ETUVAGE | non nécessaire | | | | | | | | | | | | | | | | |
| 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 |