### SUBMERGED ARC CONSUMABLES

# PRODUCT DATA SHEET

## SUBARC 308H

(Flat and Fillet Pic's)

### DESCRIPTION

Afrox Sub Arc 308H is designed to match unstabilised 18Cr 10Ni austenitic stainless steels for elevated temperature and oxidation resistance. These steels and the weld metal have a carbon content controlled to 0.04-.0.8%. The 308H consumables can also be considered for welding >12mm thick stabilised 321H or 347H to avoid in service HAZ cracking and low creep rupture associated with 347 weld metal.

## **CLASSIFICATION (Wire)**

AWS A5.9	ER308H
BS EN 12072	<u> 19 9 H</u>
DIN 8556	SG X5CrNi 19 9

## **TYPICAL CHEMICAL ANALYSIS (Wire)**

% Carbon	0.05	% Chromium	19.90
% Manganese	1.80	% Nickel	9.50
% Silicon	0.40	% Molybdenum	0.10
% Phosphorus	0.015	% Copper	0.10
% Sulphur	0.002		

#### **TYPICAL MECHANICAL PROPERTIES** (ALL WELD METAL)

Flux	MK-SS
Tensile Strength (MPa)	620
2% Proof Stress (MPa)	450
Elongation 4d %	43
Charpy Impact Value J @+20°C	100

# **PACKING DATA & OPERATING PARAMETERS**

SAW wire	Curren	Current (DC+ / AC)		Pack Mass
Diameter mm	Amps	Volts	Item Number	(Kg)
3.20mm	500	28	078385	25
4.00mm	550	28	078385	25

For more detail on the fluxes used, please refer to the relevant flux data sheet.



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