

AA 308H

CATEGORY	FCAW Flux-Cored																																		
TYPE	Rutile fluxcored stainless steel wire with high carbon content																																		
APPLICATIONS	Welding stainless steel types with an alloy content between 16 to 21% Cr and 8 to 13 % Ni, with high carbon content. High weld metal quality and attractive bead appearance																																		
PROPERTIES	Smooth drop transfer and stable arc with no spatter losses. Excellent productivity and weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness and excellent slag removal. Excellent for use in horizontal and down hand position																																		
CLASSIFICATION	AWS	A 5.22: E 308HT1-1/-4																																	
	EN ISO	17633-A: TZ 19 9 H R C/M 3																																	
	DIN: W.Nr.	1.4302																																	
	DIN	8556: 19 9																																	
SUITABLE FOR	Heat resisting stainless steel: UNS S30409, AISI 304H, 1.4848, UNS S32109, 321H, 1.4841, UNS S34709, 347H, 1.4948, 1.4961, 1.4850, X6CrNiNb 18-10, 18-11, X12CrNiTi 18-9																																		
APPROVALS	CE approved																																		
WELDING POSITIONS:																																			
WELD METAL WEIGHT %	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>S</th> <th>P</th> </tr> </thead> <tbody> <tr> <td>0,06</td> <td>1,40</td> <td>0,88</td> <td>20,50</td> <td>10,50</td> <td>-</td> <td>0,008</td> <td>0,019</td> </tr> </tbody> </table>						C	Mn	Si	Cr	Ni	Mo	S	P	0,06	1,40	0,88	20,50	10,50	-	0,008	0,019													
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REDRYING TEMPERATURE	150°C/24hr																																		
GAS ACC. EN ISO 14175	M21-C1																																		