



Cromarod 308H

SMAW - (Stick) - MMA
Stainless Steel

Date: 2013-10-21
Revision: 16

Description:

Cromarod 308H is a all-positional rutile flux coated electrode which deposits a 20%Cr / 10%Ni austenitic stainless steel weld metal with controlled carbon content (0.04% - 0.08%). It is designed to weld similar composition steels, used for creep strength and oxidation resistance at temperatures up to 800°C. Exceptionally good arc stability, weld pool control and re-striking characteristics make it particular suitable for pipewelding. Cromarod 308H is also recommended for welding the controlled carbon stabilised grades 321H and 347H, used for structural applications at temperatures above 400 °C.

Welding positions:



Coating type:

Rutile

Welding current:

DC+, AC OCV > 39V

Ferrite content:

FN 4 (WRC-92)

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min	0,04		0,5			18,0	9,0
Typical	0,05	0,7	0,8	0,02	0,02	19,5	10,0
Max	0,08	1,0	2,0	0,030	0,025	21,0	11,0

	Mo	Cu	V	Nb
Min				
Typical	0,1			
Max	0,5	0,5	0,1	0,1

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	435 MPa
Tensile Strength, Rm:	≥ 560 MPa	585 MPa
Elongation, A5	≥ 35%	39%
Impact energy, CV:	20 °C • ≥ 50 J	20 °C • 75 J

Classification:

AWS A5.4 E308H-17
ISO 3581-A E 19 9 R 12

Approvals:

CE

Note

Core wire:
P ≤ 0.020%
S ≤ 0.015%
N ≤ 0.080%

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	300	74282500	35-85	21	0,68	95	0,9	45
3,2	350	74283200	40-100	23	0,73	46	1,4	53
4,0	350	74284000	100-160	24	0,65	30	1,6	65