



# CEWELD AA 308H

TYPE	Rutile fluxcored stainless steel wire with high carbon content. ( Type 308H, 19 9 )																
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	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	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: E308HT0-4</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 19 9 H R M21 3</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 5.22: E308HT0-4	EN ISO	17633-A: T 19 9 H R M21 3	W.Nr.	1.4302	F-nr	6	FM	5						
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SUITABLE FOR	<p><b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9 % Ni, , TÜV 1000: Gr. 21</b>            1.4301, 1.4308, 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>																
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TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.06</td> <td>0.9</td> <td>1</td> <td>0.015</td> <td>0.008</td> <td>19</td> <td>10</td> <td>0.3</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	0.06	0.9	1	0.015	0.008	19	10	0.3
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REDRYING	140°C / 24 hr																
GAS ACC. EN ISO 14175	M21																