



# Inox 308 HB (DC+)

## STAINLESS STEEL

### DESCRIPTION

**Austenitic stainless steel electrode**, basic type coating with approx. 5% ferrite and increased carbon content. Stable arc, good slag removal, regular weld beads. Good behaviour in positional welding and on bad prepared joints. Excellent mechanical properties. Used on 18/8 stainless steels (304H- type) for elevated service temperatures up to + 750°C.

### CLASSIFICATION

AWS A5.4: E308H-15

EN 1600: E 19 9 H B 4 2

ISO 3581-A: E 19 9 H B 4 2

### TYPICAL APPLICATIONS

Petrochemical industry: tubes, heat exchangers, piping systems.

### BASE MATERIALS:

UNS	Alloy	EN 10088	Material N°	UGINE
S30409	304H	X6CrNi18-11	1.4948	
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B, D, E
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
		X10CrNiTi18-10	1.6903	
		X10CrNi18-8	1.431	

### PROCEDURE

Redrying 1 hour at 250°C if necessary. Interpass temperature : < 150°C.

### MECHANICAL PROPERTIES

Tensile strength: > 81 221 psi (> 560 MPa)  
 Yield strength: > 55 114 psi (> 380 MPa)  
 Elongation: > 35 %  
 Impact (Charpy V): > 80 J at +20°C

### TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Fe
0.05	1.8	0.4	19.5	9.5	Rem.

### WELDING PARAMETERS

Diameter: 4.0 mm (5/32")    3.2 mm (1/8")    2.5 mm (3/32")  
 Amperage: 120 A    90 A    70 A

### WELDING POSITIONS



Rev.: 14\_08

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