

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														
C	Mn	Si	Cr	Ni	Mo	S	P																													
0,06	1,40	0,88	20,50	10,50	-	0,008	0,019																													
MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">gas type</th> <th rowspan="2">R_{p0,2} (N/mm²)</th> <th rowspan="2">R_m (N/mm²)</th> <th rowspan="2">A₅ (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness HRC / HV</th> </tr> <tr> <th>+20°C</th> <th>-40°C</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>M21</td> <td>470</td> <td>630</td> <td>35</td> <td>80</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>						gas type	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV	+20°C	-40°C	-60°C	M21	470	630	35	80														
gas type	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V							Hardness HRC / HV																									
				+20°C	-40°C	-60°C																														
M21	470	630	35	80																																
WELDING PARAMETERS PACKING	<table border="1"> <thead> <tr> <th rowspan="2">D (mm)</th> <th colspan="3">Welding Parameters</th> <th colspan="3">Packing</th> </tr> <tr> <th>Voltage (V)</th> <th>Current (A)</th> <th>spool type</th> <th>kg / spool</th> <th>kg / pallet</th> </tr> </thead> <tbody> <tr> <td>0,9</td> <td>18-28</td> <td>80-180</td> <td>D-300 / K-300</td> <td>12,5</td> <td>900</td> </tr> <tr> <td>1,2</td> <td>23-35</td> <td>100-270</td> <td>D-300 / K-300</td> <td>15</td> <td>1080</td> </tr> <tr> <td>1,6</td> <td>25-36</td> <td>150-310</td> <td>D-300 / K-300</td> <td>15</td> <td>1080</td> </tr> </tbody> </table>						D (mm)	Welding Parameters			Packing			Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet	0,9	18-28	80-180	D-300 / K-300	12,5	900	1,2	23-35	100-270	D-300 / K-300	15	1080	1,6	25-36	150-310	D-300 / K-300	15	1080
D (mm)	Welding Parameters			Packing																																
	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet																															
0,9	18-28	80-180	D-300 / K-300	12,5	900																															
1,2	23-35	100-270	D-300 / K-300	15	1080																															
1,6	25-36	150-310	D-300 / K-300	15	1080																															
REDRYING TEMPERATURE	150°C/24hr																																			
GAS ACC. EN ISO 14175	M21-C1																																			