



## BETANOX 308H PLUS

308H TYPE STAINLESS STEEL ELECTRODE



**CLASSIFICATION : ISO 3581-A**

**AWS A/SFA 5.4**

**EN ISO 3581-A**

E 19 9 R 13

E 308H-17

E 19 9 H

### KEY FEATURES :

- Acid-Rutile based coating
- 19/10 type austenitic weld deposit
- Weld metal carbon content restricted to eliminate lowest carbon levels
- Easy slag removal
- Higher tensile and creep strengths at elevated temperatures
- Excellent corrosion and scaling resistance upto 800°C
- Radiographic weld quality

**WELDING POSITION :**



**AC (70 OCV)/DCEP**

### TYPICAL APPLICATIONS :

- Welding AISI 304H type base metals
- For high temperature applications which requires higher mechanical properties
- SS piping in refineries, oil and gas industries, chemical plants for welding of tubes, cyclones and boilers

**REDRYING CONDITION : 250-300°C for minimum 1 hr.**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>Mn</b>
Specification	0.04-0.08	18.0-21.0	9.0-11.0	0.75 max	0.5-2.5
	<b>Si</b>	<b>P</b>	<b>S</b>	<b>Cu</b>	
Specification	1 max	0.04 max	0.03 max	0.75 max	

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>EL%</b>	<b>Ferrite No.</b>
Specification	As Welded	550 min	30 min	3-8

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Cartons/Box</b>	<b>Net wt./Box, Kg</b>
2.0 x 300	50-75	2	5	10
2.5 x 350	80-100	2	5	10
3.15 x 350	100-140	2	5	10
4.0 x 350	150-180	2	5	10

**EQUIVALENT : GTAW : Tiginox 308H**