



SS 308 H

STAINLESS STEEL ELECTRODE

CLASSIFICATION : AWS/A 5.4 : E 308 H-16

CHARACTERISTICS : A rutile type stainless steel electrode suitable for welding of AISI 304, 308 & 308H grade stainless steels. The weld metal is highly resistant to corrosion, scalling and temperatures upto 800°C. Operates equally well on AC or DC (+) in all conventional positions. Excellent and consistent chemical and mechanical properties.

APPLICATIONS :

- * Welding of AISI 301, 302, 304, 308 & 308H Grades
- * Surfacing of 18/8 and clad steels of similar composition.
- * Chemical, Petro chemical & Refinery equipments.

RECOMMENDATIONS : To obtain best results redry the electrodes at 200°C for one hour. Use low current, short arc, stringer bead technique. Control interpass temperature to 150°C max. Use stainless steel wire brush for cleaning the weld.

CHEMICAL ANALYSIS OF WELD-METAL(%) :	C	Mn	Si	Cr	Ni	Mo	S	P	Cu
	0.04-0.08	0.5-2.5	1.0 max	18-21	9-11	0.75 max	0.03 max	0.04 max	0.75 max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :	Ultimate Tensile Strength N/mm ²	Elongation (GL=4d) (%)	CVN Impact Value at 27°C Joules
	550 min	35 min	70 min

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180

SPECIAL CHARACTERISTICS :

DELTA FERRITE : 5-10 FN



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