

OK Autrod 308H

A continuous solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18% Cr - 8% Ni-type. OK Autrod 308H has a good general corrosion resistance. The alloy has a high carbon content which makes this alloy suitable for applications used at higher temperatures. The alloy is used in chemical and petrochemical plants for welding of pipes, cyclones and boilers.

Specifications

Classifications	EN ISO 14343-A : G 19 9 H SFA/AWS A5.9 : ER308H
Approvals	NAKS/HAKC : 1.2mm

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic 19% Cr - 9% Ni - High C
Shielding Gas	M12, M13 (EN ISO 14175)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	N	Nb	FN WRC-92
0.05	1.9	0.5	9.2	19.8	0.06	0.01	9

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm (0.030 in.)	50-140 A	16-22 V	3.4-11.0 m/min (134-433 in./min)	0.8-2.7 kg/h (1.8-6.0 lbs/h)
1.0 mm (0.040 in.)	80-190 A	16-24 V	2.9-8.4 m/min (114-331 in./min)	1.1-3.1 kg/h (2.4-6.8 lbs/h)
1.2 mm (0.047 in.)	180-280 A	20-28 V	4.9-8.5 m/min (193-335 in./min)	2.6-4.5 kg/h (5.7-9.9 lbs/h)