

## 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

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

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

|                      |                                    |
|----------------------|------------------------------------|
| <b>Alloy Type</b>    | Austenitic 19% Cr - 9% Ni - High C |
| <b>Shielding Gas</b> | 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   | 50-140 A  | 16-22 V | 3.4-11.0 m/min  | 0.8-2.7 kg/h    |
| 1.0 mm   | 80-190 A  | 16-24 V | 2.9-8.4 m/min   | 1.1-3.1 kg/h    |
| 1.2 mm   | 180-280 A | 20-28 V | 4.9-8.5 m/min   | 2.6-4.5 kg/h    |