

Stick Electrode for Stainless Steel

KS-308H

Classification

AWS	A 5.4	E308H-16
JIS	Z3221	ES308H-16
EN	3581-A	E 19 9 H R
GB	T 983	E308H-16

Type of coating: Lime titania type

Applications and Features

- (1) Weld metal is 19%Cr-10%Ni and has higher carbon to improve tensile strength at high temperature.
- (2) It provides excellent weldability, easy slag removal and smooth beads.
- (3) It is suitable for welding high carbon 18%Cr-8%Ni steel, such as AISI 304H.

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instructions and information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni
0.060	0.55	1.75	0.012	0.005	19.21	9.83

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm ² (kgf/mm ²)	N/mm ² (kgf/mm ²)	%
580(59.1)	405(41.3)	46

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.0x250	2.6x300	3.2x350	4.0x350	5.0x350	
Amp	F/H-Fillet	35~55	50~85	80~120	100~150	140~200
	V-up/OH	30~50	45~85	70~110	90~135	—