

KS-308H

Classification

AWS A 5.4/A5.4M E308H-16

Type of coating: Lime titania type

AS/NZS 4854 B ES308H-16

Applications and Features

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

Welding Position

All Position

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 MPa	Yield Strength MPa	Elongation %
580	405	46

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.6x300	3.2x350
Amp	F/H-Fillet 50~85	80~120
	V-up/OH 45~85	70~110

Diam.	Pack / Carton	Part No.
2.5mm	2.5kg Tube x 12 = 30 kg	KS308H25
3.2mm	2.5kg Tube x 12 = 30 kg	KS308H32

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