


Technical data sheet <small>080122MBA</small>	Coated SMAW Electrode WA TETRA B 308H-E	
---	--	---

CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4:	E308H-15
EN ISO 3581-A:	E 19 9 H B 4 2
Equivalent Material number:	1.4948
ASME IX Qualification	QW432 F-N° 5 QW442 A-N° 8

DESCRIPTION AND APPLICATIONS

- Basic coated stainless steel SMAW electrode
- 18Cr-10Ni austenitic stainless steel deposit with controlled carbon for high temperature application
- Joining of steels with similar compositions, resistant to heat and scaling
- Complements Welding Alloys cored wires TETRA S 308H-G and TETRA V 308H-G

APPLICATIONS

WA TETRA B 308H-E is suitable for welding 304H and 304H derivatives that operate at temperatures up to 750°C.

Examples:

AISI	UNS	Material number	EN Symbol
304H	S30409	1.4948	X6 CrNi 18-11
321H	S32109	1.4941	X8 CrNiTi 18-10
347H	S34709	1.4961	X8 CrNiNb 16-13

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Ni	Fe
0.05	1.7	0.4	19.5	9.5	Bal.

Typical ferrite level: 5 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
550	350	30	+20°C: 40

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
600	380	40	+20°C: 100

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Current [A]	70	90	120
= +	~ 70V		

Re-drying: if necessary 1h at 250°C.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2F, 2G, 3G, 4G

PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Weight/box [kg]	5	5	5

Other packaging and other sizes: please consult us.

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.