

Stick electrode

- Features:**
- Applicable for 304 type steel for high temperature
 - Excellent mechanical properties at high temperatures

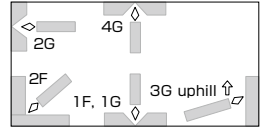
Classification: AWS A5.4 E308H-16

Redrying Conditions: 150~200°Cx0.5~1h

Identification color: 1st Yellow

Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	20	300W, 100H, 330L
3.2	350	5	20	36	175W, 125H, 380L
4.0	350	5	20	54	175W, 125H, 380L
5.0	350	5	20	80	175W, 130H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty ^a
C	0.06	0.04~0.08
Si	0.45	1.00
Mn	1.95	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	9.5	9.0~11.0
Cr	19.5	18.0~21.0
Mo	0.05	0.75
Cu	0.07	0.75

Note: ^a Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	45~80
3.2	70~115	65~110
4.0	95~145	85~135
5.0	135~180	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	403	-
TS (MPa)	572	552min.
EI on 4d (%)	48	30min.
IV 0°C (J)	79	-