

Stainless Steel Electrode

G308 H

AWS A5.4 E308H-16
JIS Z 3221 ES308H-16
ISO 3581-A-E 19 9 H R

Product Features:

- G308H is the same as G308 electrode except that the allowable carbon content higher than G308L.
- Lime-titania type electrode with 19%Cr-9%Ni deposited metal.
- Easy slag removal, good arc stability and less spatter loss
- Good bead appearance.
- Suitable for welding of SUS308H base metal.

Applications:

- 250~300 °C x 1hr baking prior to use.
- Excessively wide weaving may cause welding defects. Keep weaving width to less than 2.5 times electrode diameter.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	N	Cu	Fe
0.04	0.92	0.76	9.8	20.3	0.065	0.11	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength (N/mm ²)	Elongation (%)
474	636	42

Size (mm) & recommended welding parameters

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	350	350
Current (Amp)	F	85~120	115~150	150~190
	V,OH	75~105	95~130	-

Goodweld Corporation
No.99 Huangong Rd., Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
All Right Reserved

GOOD
GOODWELD
www.goodweld.com.tw