

SUPRANOX RS 308H

MMA Electrodes Stainless and Heat resistant steels

Semi-basic MMA electrode for welding type AISI 304H or Wr. 1.4948 steels. Developed for high temperature applications (petrochemical and nuclear industry).

Efficiency 100%. Packed in Gaspack system.

Classification	
AWS	A5.4: E 308H-16
EN	1600: E 19 9 R 12
GOST	10052-75: Э07Х20Н9

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.05	0.90	0.80	≤ 0.030	≤ 0.030	19.50	9.50	-	-	-	-	3-8

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 350	≥ 550	≥ 35	≥ 60	-

Materials

AISI 304H; 1.4948 (X6CrNi18-10); 1.4310 (X10CrNi18-8)

Storage and redrying

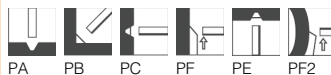
Keep dry and avoid condensation.

Re-drying not generally required

If necessary: 350-370 °C for 1 hour, 3 times max

Current condition and welding position

AC; DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	50-80	18,7	11,2
3,2	350	60-120	35,0	21,0
4,0	350	100-140	52,8	31,6