

Cored Wires Stainless and Heat resistant steels

Fluxinox 308H is an alloyed rutile cored wire for joining and surfacing of identical and similar high temperature resisting steels and cast steels. The weld metal is suitable for operating temperatures up to 700°C and is non-scaling up to approximately 800°C. Fluxinox 308H features outstanding, almost spatter-free, welding properties with very easy slag removal from fillet welds and narrow grooves. The weld beads produced are flat and smooth without undercut into the base metal. Due to only slight discoloration of the weld beads, pickling costs can be minimised.

Classification	
AWS	A5.22: E308HT0-4 / E308HT0-1

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.06	1.40	0.60	-	-	20	10	-	-	-	-	-

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	≥ 40	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

Materials

1.4941(X8CrNiTi18-10)

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

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg. 16

Diameters	1,0	1,2			
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