

MIG/MAG 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.

Classification	
EN ISO	17633-A: T 19 9 H R C 3
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EN ISO	17633-B: TS308H-FB0
AWS	A5.22: E308HT0-1
AWS	A5.22: E308HT0-4

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni
0.06	1.4	0.6	20	10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 350	≥ 550	≥ 35	≥ 40

Shielding Gas - EN ISO 14175 : C1, M21-ATAL

Materials

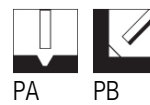
AISI 304H; 1.4948 (X6CrNi18-10); 1.4310 (X10CrNi18-8)
1.4941 (X8CrNiTi18-10)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15.0
1.0	●
1.2	●
1.6	●