

INERTROD 308H is a W 19 9 H/ER308H type solid TIG welding rod depositing a C-19Cr9Ni weld metal. Suitable for use mainly with Ar shielding gas.

INERTROD 308H is suitable for welding AISI 304H austenitic stainless steel and similar steels. It is used mainly in petrochemical industry for the fabrication of pipework and vessel.

The higher carbon content gives higher strength at elevated temperatures.

Classification

EN ISO	14343-A: W 19 9 H
AWS	A5.9: ER 308H

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni
0.060	1.9	0.5	≤ 0.020	≤ 0.020	20	10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-10 °C
As Welded	≥ 350	≥ 550	≥ 35	≥ 70	≥ 32

Gas test: 100% Ar

Shielding Gas - EN ISO 14175 : I1

Materials

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

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●
2.0	TUB	5	●
2.4	TUB	5	●
3.2	TUB	5	●