

MMA Electrodes Stainless and Heat resistant steels

SUPRANOX 308H is a semi-basic MMA electrode for welding type AISI 304H or Wr.1.4948 steels. Developed for high temperature applications in the petrochemical and nuclear industries. Efficiency 100%.

Classification

EN	1600: E 19 9 R 12
AWS	A5.4: E 308H-16
GOST	10052-75: Ø 07X20H9

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Ferrite
0.05	0.90	0.80	19.50	9.50	3-8

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	≥ 60

Materials

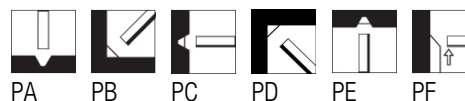
AISI 304H; 1.4948 (X6CrNi18-10); 1.4310 (X10CrNi18-8)

Storage

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

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	VPMD	
				PC	Code
2.5	300	50-80	18.7	90	●
3.2	350	60-120	35.0	60	●
4.0	350	100-140	52.8	40	●
5.0	350	140-180	81.6	20	●