

OK Autrod 308H

A continuous, solid, corrosion-resistant, chromium-nickel wire for welding austenitic chromium-nickel alloys of the 18% Cr-8% Ni type. OK Autrod 308H has good general corrosion resistance. The alloy has a high carbon content, making it suitable for applications used at higher temperatures. The alloy is used in chemical and petrochemical plants for the welding of pipes, cyclones and boilers.

Classifications Wire Electrode:	EN ISO 14343-A:G 19 9 H, SFA/AWS A5.9:ER308H
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Alloy Type:	Austenitic 19% Cr - 9% Ni - High C
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Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu
0.05	1.9	0.5	9.2	19.8	0.15	0.1

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	50-140 A	16-22 V	3.40-11.00 m/min	0.8-2.7 kg/h
1.0 mm	80-190 A	16-24 V	2,9-8,4 m/min	1,1-3,1 kg/h
1.2 mm	180-280 A	20-28 V	4,9-8,5 m/min	2,6-4,5 kg/h