



# Selectarc Inox 308HB

*Basic type Stainless Steel  
Electrode with increased carbon*

## Classification

AWS A5.4 : E308H-15

EN 1600 : E 19 9 H B 4 2

ISO 3581-A : E 19 9 H B 4 2

## Description & Applications

Austenitic stainless steel electrode, basic type coating with approx. 5% ferrite and increased carbon content. Stable arc, good slag removal, regular weld beads. Good behaviour in positional welding and on bad prepared joints. Excellent mechanical properties. Used on 18/8 stainless steels (304H- type) for elevated service temperatures up to + 750°C.

**Main applications:** Petrochemical industry: tubes, heat exchangers, piping systems.

### Base materials

### Stainless steels for high temperature applications:

UNS	Alloy	EN 10088	Material N°	UGINE
S30409	304H	X6CrNi18-11	1.4948	
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B, D, E
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
		X10CrNiTi18-10	1.6903	
		X10CrNi18-8	1.4310	

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Fe
0.05	0.4	1.8	19.5	9.5	Rem.

## All Weld Metal Mechanical Properties

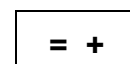
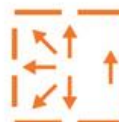
Rp0.2 ( MPa )	Rm ( MPa )	A5 ( % )	KV ( J )
>380	>560	>35	+20°C >80

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x300	3,2x350	4,0x350
Current	( A )	70	90	120

Redrying at 250°C during 1h if necessary. Interpass temperature : < 150°C.

ind.12



**Liability:** This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.